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(21) International Application Number: PCT/JP00/02203 (22) International Filing Date: 5 April 2000 (05.04.00)  (30) Priority Data: 11/106358      14 April 1999 (14.04.99)      JP 60/134,847     19 May 1999 (19.05.99)      US 11/255018      9 September 1999 (09.09.99)     JP 60/160,004     18 October 1999 (18.10.99)     US  (71) Applicant (for all designated States except US): SHOWA DENKO K. K. [JP/JP]; 13-9, Shiba Daimon 1-chome, Minato-ku, Tokyo 105-8518 (JP).  (72) Inventors; and (75) Inventors/Applicants (for US only): OBANA, Yoshiaki [JP/JP]; Oita Works, Showa Denko K. K., 2, Oaza Nakanosu, Oita-shi, Oita 870-0189 (JP). UCHIDA, Hiroshi [JP/JP]; Oita Works, Showa Denko K. K., 2, Oaza Nakanosu, Oita-shi, Oita 870-0189 (JP). SANO, Ken-ichi [JP/JP]; Kawasaki Research Laboratory, Central Research Laboratory, Showa Denko K. K., 5-1, Ogimachi, Kawasaki-ku, Kawasaki-shi, Kanagawa 210-0867 (JP).		(74) Agents: ISHIDA, Takashi et al.; A. Aoki, Ishida & Associates, Toranomon 37 Mori Bldg., 5-1, Toranomon 3-chome, Minato-ku, Tokyo 105-8423 (JP).  (81) Designated States: AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).  Published With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.	
(54) Title: CATALYST FOR PRODUCTION OF ACETIC ACID OR ACETIC ACID AND ETHYL ACETATE, PROCESS FOR ITS PRODUCTION AND PROCESS FOR PRODUCTION OF ACETIC ACID OR ACETIC ACID AND ETHYL ACETATE USING IT  (57) Abstract  An acetic acid production catalyst that contains (b) at least one element selected from the group consisting of Group 14 elements, Group 15 and Group 16 elements of the Periodic Table and/or (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, added to a palladium-loaded catalyst, as well as an acetic acid and ethylacetate production catalyst that contains (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and/or (c) at least one element selected from the group consisting of Group 14 elements, Group 15 and Group 16 elements of the Periodic Table and/or (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, added to palladium.			

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## DESCRIPTION

CATALYST FOR PRODUCTION OF ACETIC ACID OR ACETIC ACID AND  
ETHYL ACETATE, PROCESS FOR ITS PRODUCTION AND PROCESS FOR  
5 PRODUCTION OF ACETIC ACID OR ACETIC ACID AND  
ETHYL ACETATE USING IT

Cross Reference to Related Applications

This application is an application filed under 35  
10 U.S.C. § 111(a) claiming benefit pursuant to 35 U.S.C. §  
119(e)(1) of the filing dates of the Provisional  
Application No. 60/134,847, filed May 19, 1999, and the  
Provisional Application No. 60/160,004, filed October 18,  
1999, pursuant to 35 U.S.C. § 111(b).

Technical Field

The present invention relates to a catalyst for  
production of acetic acid or acetic acid and ethyl  
acetate from ethanol and oxygen, to a process for its  
20 production and to a process for production of acetic acid  
or acetic acid and ethyl acetate using the catalyst.

Background Art

Processes for industrial production of acetic acid  
25 that have been realized include a process using oxidation  
of acetaldehyde, a process using a reaction of methanol  
and carbon monoxide and a process using oxidation of  
lower paraffins. Processes for industrial production of  
ethyl acetate that have been realized include an  
30 esterification reaction of ethanol and acetic acid, and a  
dimerization reaction of acetaldehyde.

In recent years, various production processes for  
acetic acid using ethanol as the starting material have  
been studied as an alternative.

35 An example of a process for obtaining acetic acid  
from ethanol in a single stage which employs copper oxide  
as the main catalyst in combination with zinc oxide,

chromium oxide and (chromium oxide-manganese oxide)  
(Japanese Unexamined Patent Publication No. 57-102835)  
has been disclosed. However, this process has been  
difficult to apply on an industrially practical scale  
because the reaction temperature is high at 260-360°C,  
and the acetic acid selectivity is not sufficient.

Oxidation processes with catalysts of platinum group  
metals, particularly palladium, have also been disclosed.  
For example, acetic acid can be obtained by reacting a  
catalyst of metallic palladium or palladium loaded on a  
carrier such as silica or alumina (Japanese Examined  
Patent Publication No. 48-19292, Brazil Patent BR-  
9104562) with ethanol and oxygen. Palladium catalysts  
offer the advantage of a relatively low reaction  
temperature of 100-200°C. However, these processes have  
all had the drawback of abundant by-products such as  
acetaldehyde and carbon dioxide, which have lowered the  
yield of the target acetic acid.

Processes using metallic palladium-loaded catalysts  
have been disclosed as processes for obtaining ethyl  
acetate from ethanol by a single stage. For example,  
according to Kunugi and Matsuura et al. (Kogyo Kagaku  
Zasshi, Vol.71, No.9, p.1517 (1968)), ethyl acetate is  
obtained from ethanol and oxygen in the vapor phase using  
a catalyst of metallic palladium loaded on a carrier of  
active carbon,  $\gamma$ -alumina or the like. Ethyl acetate is  
also obtained from ethanol and oxygen using a metallic  
palladium/ $\gamma$ -alumina catalyst (Brazil Patent BR-8901776).  
However, these processes have had the disadvantage of a  
low conversion rate of ethanol and abundant by-products  
such as acetaldehyde, methane and carbon dioxide, which  
have lowered yields of the target ethyl acetate.

There has also been disclosed a catalyst including a  
palladium component and crystalline titanium  
pyrophosphate represented by  $(\text{TiP}_2\text{O}_7)$  (Japanese  
Unexamined Patent Publication No. 4-300851). Here,



improvement in ethyl acetate production activity has been reported by use of this binary catalyst having palladium and titanium pyrophosphate as essential components, but even this process has low ethyl acetate production activity and selectivity, and is inadequate in practical terms on an industrial scale.

On the other hand, processes employing palladium as the catalyst allow acetic acid and/or ethyl acetate to be obtained from ethanol and oxygen under relatively mild reaction conditions. Notwithstanding, for industrial scale production, a catalyst that is capable of catalyzing the reaction with even higher activity and higher selectivity is strongly desired.

#### Disclosure of Invention

It is an object of the present invention to provide a catalyst to be used for production of acetic acid or acetic acid and ethyl acetate from ethanol and oxygen, a process for its production, and a process for production of acetic acid or acetic acid and ethyl acetate using the catalyst.

In order to achieve this object, the present inventors have conducted diligent research aimed at further increasing catalyst performance in a process for producing acetic acid or acetic acid and ethyl acetate from ethanol and oxygen using a palladium catalyst, and as a result we have completed the present invention upon finding a catalyst with very low carbon dioxide selectivity, high activity and a long service life.

Specifically, the invention (I) is a catalyst for production of acetic acid, which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium and (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table, held on a carrier.

The invention (II) is a catalyst for production of acetic acid, which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, held on a carrier.

The invention (III) is a catalyst for production of acetic acid, which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, held on a carrier.

The invention (IV) is a process for production of a catalyst according to any one of the inventions (I) to (III).

The invention (V) is a process for production of acetic acid from ethanol and oxygen using a catalyst according to any one of the inventions (I) to (III).

The invention (VI) is a catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium and (b) at least one compound selected from the group consisting of inorganic acids and salts thereof.

The invention (VII) is a catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises

(a) metallic palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table.

The invention (VIII) is a catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table.

The invention (IX) is a catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table, and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table.

The invention (X) is a catalyst for production of acetic acid and ethyl acetate according to any one of the inventions (VI) to (IX), wherein the catalyst components are held on a carrier.

The invention (XI) is a process for production of a catalyst according to any one of the inventions (VI) to (IX) that is not held on a carrier.

The invention (XII) is a process for production of

the carrier-held catalyst of the invention (X).

The invention (XIII) is a process for production of acetic acid and ethyl acetate from ethanol and oxygen, using a catalyst according to any one of the inventions (VI) to (X).

#### Best Mode for Carrying Out the Invention

A catalyst for production of acetic acid according to the invention (I) will be explained first. The catalyst of the invention (I) is a catalyst for production of acetic acid which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium and (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table (hereinafter may be referred to as group (b) element), held on a carrier.

The palladium contained in the catalyst of the invention (I) is metallic palladium, and it has a valency of 0. The metallic palladium can be obtained by using a reducing agent such as hydrazine, hydrogen or the like to reduce a divalent and/or tetravalent palladium ion. All of the palladium need not be in a metallic state.

As the (b) Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table used for the invention (I) there may be mentioned selenium, tellurium, antimony, tin, bismuth and lead, but there is no restriction to these. Tellurium, selenium, bismuth and antimony are particularly preferred for the group (b) elements in terms of catalyst performance and practicality.

The carrier used for the catalyst of the invention (I) is not particularly restricted, and it may be a common porous substance commonly used for carriers. As preferred substances there may be mentioned silica, alumina, silica-alumina, diatomaceous earth, montmorillonite and titania, or ion exchange resins,

polymer-based carriers, etc. with silica being most preferred. The form of the carrier is not particularly restricted. Specifically there may be mentioned the forms of powder, spheres, pellets and the like, but there is no limitation to these. The particle size of the carrier is not especially restricted. The particle size of the carrier is preferably from about 1 mm to about 10 mm, and more preferably 3 to 8 mm. When the reaction is carried out by packing the catalyst into a cylindrical reactor, a particle size that is under 1 mm will result in a large pressure loss when the gas flows through, and this may result in problems such as an inability to achieve effective gas circulation. If the particle size is greater than 10 mm, the reaction gas can no longer diffuse into the catalyst interior, and this may impede effective catalytic reaction.

The pore volume of the carrier is not particularly restricted. It is preferably a pore volume of from about 0.2 ml to about 2.0 ml, and more preferably 0.3 to 1.5 ml, per gram of the carrier. There are no particular restrictions on the specific surface area of the carrier. It is preferably a specific surface area of 20 to 800 m<sup>2</sup>, and more preferably 50 to 500 m<sup>2</sup>, per gram of the carrier. There are also no particular restrictions on the pore diameter of the carrier. It is preferably in the range of 1 to 2000 nm, and more preferably 3 to 800 nm.

The catalyst for production of acetic acid according to the invention (I) is a binary catalyst containing (a) metallic palladium and a group (b) element. Although the structure of the catalyst has not been fully elucidated, the palladium is metallic palladium and the group (b) element is in the form of a metal, a compound or an alloy with metallic palladium, and when these are combined they are believed to exist very close together. The (a) metallic palladium and the group (b) element therefore interact expressing very high activity and selectivity.

The compositional ratio of the (a) metallic palladium and the one or more group (b) elements is preferably (a) 1 gram:(b) 0.005 to 10 grams, and more preferably (a) 1 gram:(b) 0.01 to 5 grams.

5       The loading amount of the (a) metallic palladium with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is normally preferred to be in the range of 0.05-10 wt% with respect to the carrier. Although the reaction will  
10       still proceed adequately even if the palladium loading amount is under 0.1 wt%, this presents the risk of lower productivity. Also, although the reaction will still proceed adequately even if the amount is over 10 wt%, the high price of palladium renders this undesirable in  
15       economic and practical terms. In practice, the range is more preferably 0.2-6 wt%. Here, "wt%" with respect to the carrier refers to the value of the weight of the metallic palladium divided by the weight of the carrier.

20       The loading amount of the group (b) element with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 0.0001-3 wt%, and more preferably in the range of 0.001-2.0 wt%, with respect to the carrier. Here, "wt%" with respect to the carrier  
25       refers to the value of the weight of the group (b) element divided by the weight of the carrier.

30       The amount of the components in the catalyst according to the invention (I) can be measured in the following manner. After pulverizing a prescribed amount of the catalyst with a mortar or the like into a uniform powder, it is added to an acid such as hydrofluoric acid or aqua regia and dissolved by heating and stirring to prepare a homogeneous solution. The solution is then  
35       quantitatively analyzed with a plasma emission analyzer apparatus (for example, an SPS-1700 manufactured by Seiko Electronic Industries, KK.). The precision of the apparatus can be easily adjusted with commercially

available standard reagents of different elements, and repeatable quantitation is possible.

A catalyst for production of acetic acid according to the invention (II) will now be explained. The

5 catalyst of the invention (II) is a catalyst for production of acetic acid which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium and (c) at least one element selected from the group  
10 consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table (hereinafter may be referred to as group (c) element), held on a carrier.

15 The (a) metallic palladium in the catalyst of the invention (II) is the same as for the catalyst of the invention (I). The carrier is also the same as for the catalyst of the invention (I).

The (c) Group 6 elements, Group 7 elements, Group 8  
20 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table used in the catalyst of the invention (II) include, specifically, chromium, zinc, gold, nickel, ruthenium and the like, but there is no restriction to these. As  
25 preferred group (c) elements from the standpoint of catalyst performance and practicality there may be mentioned zinc, gold and chromium.

The catalyst for production of acetic acid according to the invention (II) is a binary catalyst containing (a)  
30 metallic palladium and a group (c) element. Although the structure of the catalyst has not been fully elucidated, the palladium is metallic palladium and the group (c) element is in the form of a metal, a compound or an alloy with metallic palladium, and when these are combined they  
35 are believed to exist very close together. The (a) metallic palladium and the group (c) element therefore interact expressing very high activity and selectivity,

and exhibiting very low carbon dioxide selectivity with excellent acetic acid production activity and selectivity, compared to prior art catalysts.

5 The compositional ratio of the (a) metallic palladium and the one or more group (c) elements in the catalyst of the invention (II) is preferably (a) 1 gram:(c) 0.005 to 10 grams, and more preferably (a) 1 gram:(c) 0.01 to 5 grams.

10 The loading amount of the (a) metallic palladium with respect to the carrier is the same as for the catalyst of the invention (I).

15 The loading amount of the group (c) element with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 0.0001-3 wt%, and more preferably in the range of 0.001-2 wt%, with respect to the carrier. Here, "wt%" with respect to the carrier refers to the value of the weight of the group (c) element divided by the weight of the carrier.

20 The amount of the components in the catalyst according to the invention (II) can be measured by the same method as for the catalyst of the invention (I).

25 A catalyst for production of acetic acid according to the invention (III) will now be explained. The catalyst of the invention (III) is a catalyst for production of acetic acid which is a catalyst used in a process for production of acetic acid by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one element selected from the group  
30 consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group  
35 12 elements of the Periodic Table, held on a carrier.

The (a) metallic palladium in the catalyst of the invention (III) is the same as for the catalyst of the



invention (I).

Also, in the catalyst of the invention (III), the (b) Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are the same as for the catalyst of the invention (I), and the (c) Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are the same as for the catalyst of the invention (II). The carrier is also the same as for the catalyst of the invention (II).

The catalyst for production of acetic acid according to the invention (III) is a ternary catalyst containing (a) metallic palladium, a group (b) element and a group (c) element. Although the structure of the catalyst has not been fully elucidated, the palladium is metallic palladium, and the group (b) element and the group (c) element are each in the form of a metal, a compound or an alloy with metallic palladium, and when these are combined they are believed to exist very close together. The (a) metallic palladium, the group (b) element and the group (c) element therefore interact expressing very high activity and selectivity, and exhibiting very low carbon dioxide selectivity with excellent acetic acid production activity and selectivity, compared to prior art catalysts.

The compositional ratio of the (a) metallic palladium, the one or more group (b) elements and the one or more group (c) elements in the catalyst of the invention (III) is preferably (a) 1 gram:(b) 0.005-10 grams:(c) 0.005 to 10 grams, and more preferably (a) 1 gram:(b) 0.01-5.0 grams:(c) 0.01 to 5 grams.

The loading amount of the (a) metallic palladium and the loading amount of the group (b) element with respect to the carrier are the same as for the catalyst of the invention (I), and the loading amount of the group (c) element is the same as for the catalyst of the invention (II).

The amount of the components in the catalyst according to the invention (III) can be measured by the same method as for the catalyst of the invention (I).

5 The process of the invention (IV) will now be explained. The process of the invention (IV) is a process for production of a catalyst for production of acetic acid according to the invention (I), (II) or (III).

10 The catalyst for production of acetic acid according to the invention (I) can be produced by the following production process (1) or (2).

Production process (1) for a catalyst for production of acetic acid according to the invention (I) comprises the following steps 1 and 2.

15 Step 1

A step wherein the (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

20 A step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid.

25 Production process (2) for a catalyst for production of acetic acid according to the invention (I) comprises the following steps 1 and 2.

Step 1

30 A step wherein a palladium compound and (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

35 Step 2

A step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a

catalyst for production of acetic acid.

In step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I), the palladium compound serving as the starting material for the metallic palladium is not particularly restricted. In most cases it is possible to use compounds that can be converted to palladium metal, for example, halides such as palladium chloride, organic acid salts such as palladium acetate, and also palladium nitrate, palladium oxide, palladium sulfate and sodium tetrachloropalladate, as well as palladium metal itself.

There are no particular restrictions on the method of loading the metallic palladium or the palladium compound that can be converted to metallic palladium on the carrier, and it may be loaded by any method. For example, when loading a palladium compound that can be converted to metallic palladium, the palladium compound may be dissolved or suspended in an appropriate solvent such as water or acetone, in an inorganic acid or organic acid such as hydrochloric acid, nitric acid, acetic acid, or the like, or a solution thereof, and then loaded onto the carrier and dried, as the method of loading onto the carrier.

As loading means there may be mentioned the impregnation method, evaporation to dry hardness method, kneading method and spray method, but there is no limitation to these.

When loading a palladium compound that can be converted to metallic palladium, there are no particular restrictions on the method of subsequently converting the palladium compound to metallic palladium, i.e. the method of reduction treatment. The reduction treatment may be carried out in either a liquid phase or vapor phase state, with no particular restrictions so long as the conditions are common reducing conditions.

Liquid phase reduction treatment is usually carried out at room temperature, but it may also be conducted

with heating to a higher temperature of, specifically, about 30-50°C. Vapor phase reduction treatment is preferably carried out with heating of the palladium compound-loaded carrier to about 100-600°C in order to achieve total conversion to palladium metal.

Specifically there may be mentioned a method whereby the palladium compound is reduced to metallic palladium by hydrazine, formalin, hydrogen, methanol, ethylene or the like, either directly or after treatment with an aqueous solution of sodium hydroxide, potassium hydroxide, barium hydroxide, sodium metasilicate, etc. to convert the palladium compound to an oxide, hydroxide, or the like.

The procedure for conversion of the palladium compound that can be converted to metallic palladium into metallic palladium may be carried out after separating the catalyst carrying the palladium compound, or it may be carried out immediately following the loading procedure. If conditions permit, it is preferably carried out immediately following the loading procedure, without separation. If necessary, the metallic palladium-loaded catalyst may be filtered by a common method and then washed and dried to remove any reaction-inhibiting substances for the catalytic reaction, such as halides or alkali salts of sodium, etc.

The metallic palladium-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (I) is a step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid.

The starting material of the (b) at least one element selected from the group consisting of Group 14

elements, Group 15 elements and Group 16 elements of the Periodic Table is not particularly restricted, and it may be the element itself or a halide, nitrate, acetate, phosphate, sulfate or oxide containing the element, or  
5 even a complex with an organic molecule such as acetylacetonato or nitrile as the ligand.

Specifically there may be mentioned chlorides such as selenium chloride, tellurium chloride, antimony chloride, tin chloride, bismuth chloride, lead chloride,  
10 etc.; nitrates such as antimony nitrate, tin nitrate, bismuth nitrate, lead nitrate, etc.; acetates such as tin acetate, bismuth acetate, lead acetate, etc.; and selenium oxide, selenic acid ( $H_2SeO_4$ ) and its salts, selenious acid ( $H_2SeO_3$ ) and its salts, metallic selenium,  
15 tellurium oxide, telluric acid ( $H_6TeO_6$ ) and its salts, tellurous acid ( $H_2TeO_3$ ) and its salts, metallic tellurium and the like, but there is no limitation to these.

There are no particular restrictions on the method of loading the starting material for the group (b)  
20 element on the carrier, and it may be loaded by any method. For example, the starting material for the group (b) element may be dissolved or suspended in an appropriate solvent such as water or acetone, or in an inorganic acid or organic acid such as hydrochloric acid,  
25 nitric acid, acetic acid, or the like and then impregnated into the carrier and dried, as the method of loading onto the carrier.

As loading means there may be mentioned the impregnation method, evaporation to dry hardness method,  
30 kneading method and spray method, but there is no limitation to these.

A catalyst for production of acetic acid according to the invention (I) can be obtained in the manner described above.

35 Step 1 of production process (2) for a catalyst for production of acetic acid according to the invention (I) is a step wherein a palladium compound and (b) at least

one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

5 In step 1 of production process (2) for a catalyst for production of acetic acid according to the invention (I), the palladium compound serving as the starting material for the metallic palladium and its loading method are the same as in step 1 of production process  
10 (1) for a catalyst for production of acetic acid according to the invention (I).

The starting material for the group (b) element and its loading method are also the same as in step 2 of production process (1) for a catalyst for production of  
15 acetic acid according to the invention (I).

The loading of the palladium compound that can be converted to metallic palladium on the carrier and the loading of the starting material for the group (b) element on the carrier may be carried out in any order.  
20 That is, both loadings may be carried out simultaneously, or one before the other. However, it is preferred for loading of the group (b) element on the carrier to be carried out simultaneously with loading of the palladium compound.

25 The palladium compound-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (2) for a catalyst for production of acetic acid according to the invention (I) is a step wherein the palladium compound-loaded catalyst  
30 obtained in step 1 is reduced to obtain a catalyst for production of acetic acid.

For a catalyst having a palladium compound that can be converted to metallic palladium and/or a starting compound for a group (b) element held on a carrier, the  
35 method for conversion of these compounds to their respective metal elements, i.e. the method of reduction treatment, is not particularly restricted. The reduction

treatment is the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

5 A catalyst for production of acetic acid according to the invention (I) can be obtained in the manner described above.

A catalyst for production of acetic acid according to the invention (II) can be produced by the following production process (3) or (4).

10 Production process (3) for a catalyst for production of acetic acid according to the invention (II) comprises the following steps 1 and 2.

Step 1

15 A step wherein the (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

20 A step wherein (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid.

25 Production process (4) for a catalyst for production of acetic acid according to the invention (II) comprises the following steps 1 and 2.

Step 1

30 A step wherein a palladium compound and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

35 Step 2

A step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a

catalyst for production of acetic acid.

In step 1 of production process (3) for a catalyst for production of acetic acid according to the invention (II), the palladium compound serving as the starting material for the metallic palladium, its loading method and the method for its conversion to metallic palladium are the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

Step 2 in production process (3) for a catalyst for production of acetic acid according to the invention (II) is step wherein (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid.

The (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is not particularly restricted, and it may be the element itself or a halide, nitrate, acetate, phosphate, sulfate or oxide containing the element, or even a complex with an organic molecule such as acetylacetonato or nitrile as the ligand.

Specifically there may be mentioned chlorides such as chromium chloride, manganese chloride, rhenium chloride, ruthenium chloride, rhodium chloride, iridium chloride, nickel chloride, tetrachloro aurate and its salts, chlorides such as zinc chloride, etc.; nitrates such as chromium nitrate, manganese nitrate, nickel nitrate, iridium nitrate, zinc nitrate, etc.; acetates such as chromium acetate, manganese acetate, rhenium acetate, ruthenium acetate, iridium acetate, nickel acetate, zinc acetate, and the like, but there is no



limitation to these.

There are no particular restrictions on the method of loading the starting material for the group (c) element on the carrier, and it may be loaded by any method. For example, the starting material for the group (c) element may be dissolved or suspended in an appropriate solvent such as water or acetone, or in an inorganic acid or organic acid such as hydrochloric acid, nitric acid, acetic acid or the like and then impregnated into the carrier and dried, as the method of loading onto the carrier. As loading means there may be mentioned the impregnation method, evaporation to dry hardness method, kneading method and spray method, but there is no limitation to these.

A catalyst for production of acetic acid according to the invention (II) can be obtained in the manner described above.

Step 1 in production process (4) for a catalyst for production of acetic acid according to the invention (II) is a step wherein a palladium compound and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

In production process (4) for a catalyst for production of acetic acid according to the invention (II), the palladium compound serving as the starting material for the metallic palladium and its loading method are the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

The starting material for the group (c) element and its loading method are the same as in step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (II).

The loading of the palladium compound that can be

converted to metallic palladium on the carrier and the loading of the starting material for the group (c) element on the carrier may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other. However, it is preferred for loading of the group (c) element on the carrier to be carried out simultaneously with loading of the palladium compound.

Step 2 in production process (4) for a catalyst for production of acetic acid according to the invention (II) is step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a catalyst for production of acetic acid.

For a catalyst having a palladium compound that can be converted to metallic palladium and/or a starting compound for a group (c) element held on a carrier, the method for conversion of these compounds to their respective metal elements, i.e. the method of reduction treatment, is not particularly restricted. The reduction treatment is the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

A catalyst for production of acetic acid according to the invention (II) can be obtained in the manner described above.

A catalyst for production of acetic acid according to the invention (III) can be produced by the following production process (5) to (8).

Production process (5) for a catalyst for production of acetic acid according to the invention (III) comprises the following steps 1 and 2.

Step 1

A step wherein metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15

elements and Group 16 elements of the Periodic Table and  
(c) at least one element selected from the group  
consisting of Group 6 elements, Group 7 elements, Group 8  
elements, Group 9 elements, Group 10 elements, Group 11  
5 elements and Group 12 elements of the Periodic Table are  
loaded on the metallic palladium-loaded catalyst obtained  
in step 1 to obtain a catalyst for production of acetic  
acid.

10 Production process (6) for a catalyst for production  
of acetic acid according to the invention (III) comprises  
the following steps 1 and 2.

Step 1

15 A step wherein a palladium compound, (b) at least  
one element selected from the group consisting of Group  
14 elements, Group 15 elements and Group 16 elements of  
the Periodic Table and (c) at least one element selected  
from the group consisting of Group 6 elements, Group 7  
elements, Group 8 elements, Group 9 elements, Group 10  
elements, Group 11 elements and Group 12 elements of the  
20 Periodic Table are loaded on a carrier to obtain a  
palladium compound-loaded catalyst.

Step 2

25 A step wherein the palladium compound-loaded  
catalyst obtained in step 1 is reduced to obtain a  
catalyst for production of acetic acid.

Production process (7) for a catalyst for production  
of acetic acid according to the invention (III) comprises  
the following steps 1 to 3.

Step 1

30 A step wherein a palladium compound and (b) at least  
one element selected from the group consisting of Group  
14 elements, Group 15 elements and Group 16 elements of  
the Periodic Table are loaded on a carrier to obtain a  
palladium compound-loaded catalyst.

35 Step 2

A step wherein the palladium compound-loaded  
catalyst obtained in step 1 is reduced to obtain a

metallic palladium-loaded catalyst.

Step 3

5 A step wherein (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 2 to obtain a catalyst for production of acetic acid.

10 Production process (8) for a catalyst for production of acetic acid according to the invention (III) comprises the following steps 1 to 3.

Step 1

15 A step wherein a palladium compound and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

20 Step 2

A step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a metallic palladium-loaded catalyst.

Step 3

25 A step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 2 to obtain a catalyst for production of acetic acid.

30

35 In step 1 of production process (5) for a catalyst for production of acetic acid according to the invention (III), the palladium compound serving as the starting material for the metallic palladium, its loading method and the method for its conversion to metallic palladium are the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the

invention (I).

In step 2 of production process (5) for a catalyst for production of acetic acid according to the invention (III), the starting material for the (b) at least one  
5 element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and its loading method are the same as in step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

10 The starting material for the group (c) element and its loading method are the same as in step 2 of production process (3) for a catalyst for production of acetic acid according to the invention (II).

15 A catalyst for production of acetic acid according to the invention (III) can be obtained in the manner described above.

In step 1 of production process (6) for a catalyst for production of acetic acid according to the invention (III), the palladium compound serving as the starting  
20 material for the metallic palladium and its loading method are the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

25 The starting material for the group (b) element and its loading method are the same as in step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

30 The starting material for the group (c) element and its loading method are the same as in step 2 of production process (3) for a catalyst for production of acetic acid according to the invention (II).

35 The loading of the palladium compound that can be converted to metallic palladium on the carrier, the loading of the starting material for the group (b) element on the carrier and the loading of the starting material for the group (c) element on the carrier may be carried out in any order. That is, all of the loadings

may be carried out simultaneously, or one before the others. However, it is preferred for loading of the group (c) element on the carrier to be carried out simultaneously with loading of the palladium compound.

5       The palladium compound-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (6) for a catalyst for production of acetic acid according to the invention (III) is a step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a catalyst for production of acetic acid.

10       For a catalyst having a palladium compound that can be converted to metallic palladium, a starting compound for a group (b) element and a starting compound for a group (c) element held on a carrier, the method for conversion of these compounds to their respective metal elements, i.e. the method of reduction treatment, is not particularly restricted. The reduction treatment is the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

15       In step 1 of production process (7) for a catalyst for production of acetic acid according to the invention (III), the palladium compound serving as the starting material for the metallic palladium and its loading method are the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

20       The starting material for the group (b) element and its loading method are the same as in step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

25       The loading of the palladium compound that can be converted to metallic palladium on the carrier and the loading of the starting material for the group (b) element on the carrier may be carried out in any order. That is, both loadings may be carried out simultaneously,

or one before the other. However, it is preferred for loading of the group (b) element on the carrier to be carried out simultaneously with loading of the palladium compound.

5           The palladium compound-loaded catalyst can be obtained in the manner described above.

          Step 2 of production process (7) for a catalyst for production of acetic acid according to the invention (III) is a step wherein the palladium compound-loaded  
10 catalyst obtained in step 1 is reduced to obtain a metallic palladium-loaded catalyst.

          For a catalyst having a palladium compound that can be converted to metallic palladium and a starting compound for a group (b) element held on a carrier, the  
15 method for conversion of these compounds to their respective metal elements, i.e. the method of reduction treatment, is not particularly restricted. The reduction treatment is the same as in step 1 of production process (1) for a catalyst for production of acetic acid  
20 according to the invention (I).

          The metallic palladium-loaded catalyst can be obtained in the manner described above.

          Step 3 of production process (7) for a catalyst for production of acetic acid according to the invention  
25 (III) is a step wherein a group (c) element is loaded on the metallic palladium-loaded catalyst obtained in step 2 to obtain a catalyst for production of acetic acid.

          The starting material for the group (c) element and its loading method are the same as in step 2 of  
30 production process (3) for a catalyst for production of acetic acid according to the invention (II).

          A catalyst for production of acetic acid according to the invention (III) can be obtained in the manner described above.

35           In step 1 of production process (8) for a catalyst for production of acetic acid according to the invention (III), the palladium compound serving as the starting

material for the metallic palladium and its loading method are the same as in step 1 of production process (3) for a catalyst for production of acetic acid according to the invention (II).

5       The starting material for the group (c) element and its loading method are the same as in step 2 of production process (3) for a catalyst for production of acetic acid according to the invention (II).

10       The loading of the palladium compound that can be converted to metallic palladium on the carrier and the loading of the starting material for the group (c) element on the carrier may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other. However, it is preferred for  
15       loading of the group (c) element on the carrier to be carried out simultaneously with loading of the palladium compound.

      The palladium compound-loaded catalyst can be obtained in the manner described above.

20       Step 2 of production process (8) for a catalyst for production of acetic acid according to the invention (III) is a step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a metallic palladium-loaded catalyst.

25       For a catalyst having a palladium compound that can be converted to metallic palladium and a starting compound for a group (c) element held on a carrier, the method for conversion of these compounds to their respective metal elements, i.e. the method of reduction  
30       treatment, is not particularly restricted. The reduction treatment is the same as in step 1 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

      The metallic palladium-loaded catalyst can be  
35       obtained in the manner described above.

      Step 3 of production process (8) for a catalyst for production of acetic acid according to the invention



(III) is a step wherein a group (b) element is loaded on the metallic palladium-loaded catalyst obtained in step 2 to obtain a catalyst for production of acetic acid.

5 The starting material for the group (b) element and its loading method are the same as in step 2 of production process (1) for a catalyst for production of acetic acid according to the invention (I).

10 A catalyst for production of acetic acid according to the invention (III) can be obtained in the manner described above.

The invention (V) is a process for production of acetic acid from ethanol and oxygen using a catalyst for production of acetic acid according to any one of the inventions (I); (II) or (III).

15 The reaction process is not particularly restricted so long as it allows a catalyst of the invention to react ethanol with oxygen, and it may be any of a variety of processes including a batch process, semi-batch process, semi-continuous process, continuous flow process or a  
20 combination thereof, for a vapor phase reaction or liquid phase reaction.

The ethanol starting material may be supplied in liquid form, or it may be supplied in vapor form. That is, the reaction process may be, for example, a semi-  
25 continuous process whereby the catalyst of the invention is suspended in liquid ethanol and/or an ethanol solution and oxygen is passed through, or a continuous flow process whereby ethanol and oxygen gas are passed through the catalyst. A vapor phase reaction process is  
30 preferred from the standpoint of separation of the catalyst, starting materials and products, and from the standpoint of acetic acid productivity. More preferred, and advantageous in practical terms, is to employ a fixed bed having corrosion-resistant reaction tubes packed with  
35 the catalyst of the invention, for a vapor phase reaction process in which the ethanol and oxygen are passed through.

A vapor phase reaction and liquid phase reaction used in the process for production of acetic acid according to the invention (V) will now be explained.

A vapor phase reaction will be explained first.

5        There are no particular restrictions on the reaction temperature for production of acetic acid by reaction of ethanol and oxygen in a vapor phase according to the acetic acid production method of the invention (V), but it is preferably 100-250°C. If the reaction temperature  
10       is below 100°C the reaction rate may be insufficient, while if it is above 250°C a greater number of secondary reactions will tend to occur. More preferred in practical terms is the range of 120-230°C.

15       The reaction pressure is not particularly restricted but in terms of the equipment it is advantageous in practice for it to be from 0.0 to 3.0 MPa (gauge pressure). It is more preferably in the range of 0.1 to 1.5 MPa (gauge pressure).

20       In the case of a flow-type reaction, the gas supplied to the reaction system comprises ethanol and oxygen, and if necessary nitrogen, carbon dioxide, a rare gas or the like may also be used as a diluent. The ethanol is supplied to the reaction system in an amount corresponding to a proportion of 0.01-50% by volume, and  
25       especially 0.1-40% by volume, and the oxygen in an amount corresponding to a proportion of 1-15% by volume, and especially 2-10% by volume, with respect to the total amount of supply gas. Here, an ethanol concentration exceeding 20% by volume will tend to increase the degree  
30       of secondary reactions, while a concentration of under 2% by volume will tend to lower the productivity.

35       The presence of water in the reaction system will provide a notable effect of improved acetic acid production activity and selectivity, as well as prolonged activity of the catalyst in the reaction system. It is suitable for water vapor to be included in the reaction gas at 0.1-50% by volume. If the water vapor in the

reaction gas is present at less than 0.1% by volume the catalyst may tend to undergo deterioration more readily, and if it is present at greater than 50% by volume, the steam unit requirement may be poorer. In practical  
5 terms, the range is most preferably 0.5-40% by volume.

When carrying out the production process for acetic acid of the invention according to this gas phase reaction there are no particular restrictions on the ethanol starting material. It is advantageous to use a  
10 high purity ethanol starting material, but there is no problem with mixing a small amount of a lower saturated hydrocarbon such as methane, ethane or propane or the like.

There are also no particular restrictions on the  
15 oxygen, and it may be in a form such as air, diluted with an inert gas such as nitrogen, carbon dioxide gas or the like. When the reaction gas is circulated it is generally more advantageous to use oxygen at a high concentration, preferably 99% or greater.

20 The reaction mixture gas consisting of ethanol and oxygen may be blended with acetaldehyde, diethyl ether or the like and supplied to the reaction system. Acetaldehyde and/or diethyl ether to be supplied together with the reaction mixture gas may be in an amount of the  
25 range of preferably 0.001-5.0% by volume, more preferably 0.01-4.0% by volume in the total reaction mixture gas.

The reaction mixture gas is preferably passed through the catalyst at a space velocity (SV) in the range of 500-15,000  $\text{hr}^{-1}$ , and especially 1000-10,000  $\text{hr}^{-1}$ ,  
30 in a standard state.

Next, a liquid phase reaction will be explained.

There are no particular restrictions on the reaction temperature for production of acetic acid by reaction of ethanol and oxygen in a liquid phase according to the  
35 acetic acid production method of the invention (V), but it is preferably 0-200°C. If the reaction temperature is below 0°C the reaction rate may be insufficient, while if

it is above 200°C a greater number of secondary reactions may occur. More preferred in practical terms is the range of 20-100°C.

5 The reaction pressure is not particularly restricted but in terms of the equipment it is advantageous in practice for it to be from 0.0 to 3.0 MPa (gauge pressure). It is more preferably in the range of 0.1 to 1.5 MPa (gauge pressure).

10 The ethanol and/or oxygen starting materials may be present in the catalyst beforehand, or they may be added at an appropriate point during the reaction. When they are supplied to the reaction system, they may be in gaseous and/or liquid form.

15 The starting material supplied to the reaction system comprises ethanol and oxygen, and if necessary nitrogen, carbon dioxide or a diluting gas may also be used.

20 The presence of water in the reaction system will provide a notable effect of improved acetic acid production activity and selectivity, as well as prolonged activity of the catalyst in the reaction system. The proportion of water and ethanol in the reaction system is not particularly restricted. The proportion of water and ethanol may even be changed during the reaction, or an  
25 appropriate amount of water may be added to keep a constant proportion. If necessary, a basic component such as sodium hydroxide may be added to increase the reaction rate.

30 When carrying out the production process for acetic acid of the invention according to this liquid phase reaction there are no particular restrictions on the ethanol starting material. It is advantageous to use a high purity ethanol starting material, but there is no problem with mixing a small amount of a lower saturated  
35 hydrocarbon such as methane, ethane or propane or the like.

There are also no particular restrictions on the

oxygen, and it may be in a form such as air, or diluted with an inert gas such as nitrogen, carbon dioxide gas or the like. When the reaction gas is circulated it is generally more advantageous to use oxygen at a high concentration, preferably 99% or greater.

The reaction mixture gas or liquid consisting of ethanol and oxygen may be blended with acetaldehyde, diethyl ether or the like and supplied to the reaction system.

The obtained acetic acid may be separated and purified by common methods to the desired degree of purity, in the case of either a gas phase reaction or a liquid phase reaction. When unreacted starting materials and by-products of acetaldehyde and/or diethyl ether remain, those unreacted starting materials and by-products of acetaldehyde and/or diethyl ether can be recovered and recycled into the reaction system for use.

When necessary, the catalyst used may be regenerated at an appropriate point or separated for repeated use.

A catalyst for production of acetic acid and ethyl acetate according to the inventions (VI) and (X) will now be explained.

The invention (VI) is a non-carrier-held catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium and (b) at least one compound selected from the group consisting of inorganic acids and salts thereof (hereinafter may be referred to as group (b) compound) or a carrier-held catalyst for production of acetic acid and ethyl acetate wherein these catalyst components are held on a carrier is one of the catalysts according to the invention (X).

The palladium contained in the catalyst of the invention (VI) is metallic palladium, and it has a valency of 0. The metallic palladium can be obtained by using a reducing agent such as hydrazine, hydrogen or the

like to reduce a divalent and/or tetravalent palladium ion. All of the palladium need not be in a metallic state.

5 As the inorganic acid of the group (b) compound there may be mentioned phosphoric acid, sulfuric acid, hydrochloric acid, nitric acid, niobic acid, heteropoly acids and the like, but there is no limitation to these. It is preferably phosphoric acid or a heteropoly acid.

10 A heteropoly acid is an acid formed by condensation of two or more inorganic oxyacids comprising a coordinated element (poly atom) and a central element (hetero atom). As the hetero atom in the heteropoly acid there may be mentioned phosphorus, silicon, boron, aluminum, germanium, cerium, cobalt and chromium, and as  
15 the poly atom there may be mentioned molybdenum, tungsten, vanadium, niobium and tantalum, but there are no particular restrictions. As specific examples there may be mentioned tungstosilicic acid, tungstophosphoric acid, molybdosilicic acid, molybdophosphoric acid,  
20 molybdotungstophosphoric acid, molybdotungstosilicic acid, vanadotungstophosphoric acid, vanadotungstosilicic acid, vanadomolybdosilicic acid, tungstoboric acid, molybdoboric acid and molybdotungstoboric acid.

25 Particularly preferred among these are heteropoly acids wherein the hetero atom is phosphorus or silicon and the polyatom is at least one element selected from the group consisting of tungsten, molybdenum and vanadium.

30 As the inorganic acid salt of the group (b) compound there may be mentioned metal salts or onium salts wherein all or a portion of the hydrogen atoms of the inorganic acid are substituted.

The metal element substituting the hydrogen atoms of the inorganic acid is not particularly restricted.  
35 Specific examples are at least one element selected from the group consisting of Group 1, Group 2, Group 6, Group 7, Group 8, Group 9, Group 10, Group 11, Group 12 and

Group 13 elements of the Periodic Table, and examples of onium salts of the inorganic acid include ammonium salts with ammonium or amines. Particularly preferred among these inorganic acid salts are metal salts of lithium, sodium, potassium, cesium, rubidium, chromium, barium, cobalt, nickel, manganese and copper.

While the structure of the catalyst has not been fully elucidated, the palladium is (a) metallic palladium, and the group (b) compound is a compound with definite acidity. The elements and compounds of these two groups (a) and (b) are believed to exist very close together, the compounds and elements of each group interacting to express very high activity and selectivity.

The compositional ratio of the (a) metallic palladium and the group (b) compound is preferably (a) 1 gram:(b) 0.025-500 grams and more preferably (a) 1 gram:(b) 0.1-400 grams.

There are no particular restrictions on the content of the (a) metallic palladium in the catalyst. However, it is preferably in the range of 0.001-10 wt%. Although the reaction will still proceed adequately even if the content of the (a) metallic palladium is under 0.001 wt%, this presents the risk of lower practical productivity. Also, although the reaction will still proceed adequately even if the content of the (a) metallic palladium is over 10 wt%, the high price of palladium renders this undesirable in economic and practical terms. In practice, the range is more preferably 0.005-8.0 wt%. Here, "wt%" refers to the proportion of the weight of the (a) metallic palladium in the catalyst with respect to the weight of the total catalyst.

The catalyst may be effectively used with only the catalyst substance having the aforementioned composition, or it may be loaded on a carrier for more advantageous use.

The carrier used is suitably porous silica, alumina,

silica-alumina, diatomaceous earth, montmorillonite, titania, an ion exchange resin or a polymer-based carrier, with silica being most suitable. The carrier may be in the form of a powder, spheres, pellets or any other desired form.

The particle size of the carrier is preferably 1-10 mm. When the reaction is carried out by packing the catalyst into a cylindrical reactor, a particle size that is under 1 mm will result in a large pressure loss when the gas flows through, and this may make it impossible to achieve effective gas circulation. If the particle size is over 10 mm, the reaction gas can no longer diffuse into the catalyst interior, and this may impede effective catalytic reaction. The particle size is more preferably 3-8 mm.

The pore volume of the carrier is preferably a pore volume of 0.2-2.0 ml, and more preferably 0.3-1.5 ml, per gram of the carrier. The specific surface area of the carrier is preferably a specific surface area of 20-800 m<sup>2</sup>, and more preferably 50-500 m<sup>2</sup>, per gram of the carrier. The pore diameter of the carrier is preferably 1-2000 nm, and more preferably 3-800 nm.

The loading amount of the (a) metallic palladium with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is normally preferred to be in the range of 0.01-10 wt% with respect to the carrier. Although the reaction will still proceed adequately even if the content of the palladium loading amount is under 0.01 wt%, this presents the risk of lower productivity. Also, although the reaction will still proceed adequately even if the amount is over 10 wt%, the high price of palladium renders this undesirable in economic and practical terms. In practice, the range is more preferably 0.2-6 wt%. Here, "wt%" refers to the proportion of the weight of the (a) metallic palladium in the catalyst with respect to the weight of the carrier.



The loading amount of the group (b) compound with respect to the carrier will also differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 5-200 wt%, and more preferably in the range of 10-100 wt%, with respect to the carrier. Here, "wt%" refers to the proportion of the weight of the group (b) compound in the catalyst with respect to the weight of the carrier.

The invention (VII) is a non-carrier-held catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table (hereinafter may be referred to as group (c) element) or a carrier-held catalyst for production of acetic acid and ethyl acetate wherein these catalyst components are held on a carrier is one of the catalysts according to the invention (X).

The catalyst of the invention (VII) is the catalyst of the invention (VI) which contains a group (c) element, and it is a ternary catalyst.

The (a) metallic palladium and the group (b) compound used for the invention (VII) are the same as according to the invention (VI).

The (c) Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table include selenium, tellurium, antimony, tin, bismuth and lead. Selenium, tellurium, tin and bismuth are preferred.

Although the structure of the catalyst has not been fully elucidated, the (a) metallic palladium and the group (b) compound are the same as for the catalyst of the invention (VI), and the same effect may be expected as with the catalyst of the invention (VI). The elements

and compounds of these three groups (a), (b) and (c) are believed to exist very close together. The (a) metallic palladium, the group (b) compound and the group (c) element therefore interact expressing very high activity and selectivity, i.e. exhibiting low selectivity for carbon dioxide and acetaldehyde while exhibiting excellent production activity and selectivity for acetic acid and ethyl acetate.

The compositional ratio of the (a) metallic palladium, the group (b) compound and the group (c) element in the catalyst is preferably (a) 1 gram:(b) 0.025-500 grams:(c) 0.005-10 grams, and more preferably (a) 1 gram:(b) 0.1-400 grams:(c) 0.01-5 grams. The content of the (a) metallic palladium in this catalyst is the same as for the catalyst of the invention (VI).

For loading on a carrier, the carrier is also the same as for the catalyst of the invention (VI).

The loading amounts of the (a) metallic palladium and the group (b) compound with respect to the carrier are the same as for the catalyst of the invention (VI).

The loading amount of the group (c) element with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 0.0001-3.0 wt%, and more preferably in the range of 0.001-2.0 wt%, with respect to the carrier. Here, "wt%" refers to the proportion of the weight of the group (c) element in the catalyst with respect to the weight of the carrier.

The invention (VIII) is a non-carrier-held catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements,

Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table (hereinafter may be referred to as group (d) element) or a carrier-held catalyst for production of acetic acid and ethyl acetate wherein these catalyst components are held on a carrier is one of the catalysts according to the invention (X).

The catalyst of the invention (VIII) is the catalyst of the invention (VI) which contains a group (d) element, and it is a ternary catalyst.

The (a) metallic palladium and the group (b) compound used for the invention (VIII) are the same as according to the invention (VI).

As the (d) Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table there may be mentioned chromium, manganese, rhenium, ruthenium, rhodium, iridium, nickel, gold and zinc. Chromium, manganese, gold and zinc are preferred.

Although the structure of the catalyst has not been fully elucidated, the (a) metallic palladium and the group (b) compound are the same as for the catalyst of the invention (VI), and the same effect may be expected as with the catalyst of the invention (VI). The elements and compounds of these three groups (a), (b) and (d) are believed to exist very close together. The (a) metallic palladium, the group (b) compound and the group (d) element therefore interact expressing very high activity and selectivity, i.e. exhibiting low selectivity for carbon dioxide and acetaldehyde while exhibiting excellent production activity and selectivity for acetic acid and ethyl acetate.

The compositional ratio of the (a) metallic palladium, the group (b) compound and the group (d) element in the catalyst is preferably (a) 1 gram:(b) 0.025-500 grams:(d) 0.005-10 grams, and more preferably (a) 1 gram:(b) 0.1-400 grams:(d) 0.01-5 grams. The content of the (a) metallic palladium in this catalyst is

the same as for the invention (VI).

For loading on a carrier, the carrier is also the same as for the catalyst of the invention (VI).

5 The loading amounts of the (a) metallic palladium and the group (b) compound with respect to the carrier are the same as for the catalyst of the invention (VI).

10 The loading amount of the group (d) element with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 0.0001-3.0 wt%, and more preferably in the range of 0.001-2.0 wt%, with respect to the carrier. Here, "wt%" refers to the proportion of the weight of the group (d) element in the catalyst, with respect to the weight of the carrier.

15 The invention (IX) is a non-carrier-held catalyst for production of acetic acid and ethyl acetate, which is a catalyst used in a process for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen that comprises (a) metallic palladium, (b) at least one  
20 compound selected from the group consisting of inorganic acids and salts thereof, (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table, and (d) at least one element selected from the  
25 group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table on a carrier-held catalyst for production of acetic acid and ethyl acetate wherein these catalyst components  
30 are held on a carrier is one of the catalysts according to the invention (X).

The catalyst of the invention (IX) is the catalyst of the invention (VII) which contains a group (d) element, and it is a quaternary catalyst.

35 The (a) metallic palladium, the group (b) compound and the group (c) element used for the invention (IX) are the same as for the catalyst of the invention (VII). The

(d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is the same as according to the invention (VIII).

Although the structure of the catalyst has not been fully elucidated, the (a) metallic palladium, the group (b) compound and the group (c) element are the same as for the catalyst of the invention (VII), and the same effect may be expected as by the catalyst of the invention (VII). The elements and compounds of these four groups (a), (b), (c) and (d) are believed to exist very close together. The (a) metallic palladium, the group (b) compound, the group (c) element and the group (d) element therefore interact expressing very high activity and selectivity, i.e. exhibiting low selectivity for carbon dioxide and acetaldehyde while exhibiting excellent production activity and selectivity for acetic acid and ethyl acetate.

The compositional ratio of the (a) metallic palladium, the group (b) compound, the group (c) element and the group (d) element in the catalyst is preferably (a) 1 gram:(b) 0.025-500 grams:(c) 0.005-10 grams:(d) 0.005-10 grams, and more preferably (a) 1 gram:(b) 0.1-400 grams:(c) 0.01-5 grams:(d) 0.01-5 grams. The content of the (a) metallic palladium in this catalyst is the same as for the catalyst of the invention (VI).

For loading on a carrier, the carrier is also the same as for the catalyst of the invention (VII).

The loading amounts of the (a) metallic palladium, the group (b) compound and the group (c) element with respect to the carrier are the same as for the catalyst of the invention (VII).

The loading amount of the group (d) element with respect to the carrier will differ depending on the particle size and pore structure of the carrier, but it is preferably in the range of 0.0001-3.0 wt%, and more

preferably in the range of 0.001-2.0 wt%, with respect to the carrier. Here, "wt%" refers to the proportion of the weight of the group (d) element in the catalyst, with respect to the weight of the carrier.

5 A process for production of a non-carrier-held catalyst of any one of the inventions (VI) to (IX) according to the invention (XI) will now be explained. The process of the invention (XI) is a process for production of a non-carrier-held catalyst for production  
10 of acetic acid and ethyl acetate according to any one of the inventions (VI), (VII), (VIII) or (IX).

Production process (1) according to the invention (XI) is a process for production of a catalyst according to the invention (VI) that comprises the following steps  
15 1 and 2.

Step 1

A step wherein a palladium suspension is obtained.

Step 2

20 A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is dissolved or suspended in the palladium suspension obtained in step 1, and the solvent is then removed.

25 Step 1 of production process (1) according to the invention (XI) is a step wherein a palladium suspension is obtained.

In production process (1) according to the invention (XI), there are no particular restrictions on the palladium compound as the starting material for the  
30 metallic palladium. Normally there may be used compounds that can be converted to metallic palladium, including halides such as palladium chloride, organic acid salts such as palladium acetate, and also palladium nitrate, palladium oxide, palladium sulfate and sodium  
35 tetrachloropalladate, or metallic palladium itself.

The palladium suspension can be obtained by dissolving or suspending the metallic palladium starting

compound in an appropriate solvent.

The solvent used here may be water or an inorganic or organic solvent such as acetone, ethanol or the like, and if necessary an inorganic or organic acid such as hydrochloric acid, nitric acid or acetic acid may be dissolved in the solvent that is used. The metallic palladium starting compound is preferably one that can be homogeneously dissolved or suspended by stirring, etc., but it is not particularly restricted. If necessary, the metallic palladium starting compound may also be subjected to reduction treatment for conversion to metallic palladium.

In the case of reduction treatment in step 1, i.e. conversion to metallic palladium of the metallic palladium starting compound that can be converted to metallic palladium, the method used therefor is not particularly restricted. Specifically there may be mentioned a method whereby the metallic palladium starting compound is reduced to metallic palladium with an appropriate reducing agent such as hydrazine, formalin, methanol, ethylene, hydrogen or the like. The reduction treatment may be carried out in either a liquid phase or vapor phase state. Liquid phase reduction treatment is usually carried out at room temperature, but it may also be conducted with heating to a higher temperature, for example, about 30-50°C. Vapor phase reduction treatment is preferably carried out with heating to about 100-600°C in order to achieve total conversion to metallic palladium.

The palladium suspension can be obtained in this manner.

Step 2 of production process (1) according to the invention (XI) is a step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is dissolved or suspended in the palladium suspension obtained in step 1, and the solvent is then removed to obtain a catalyst for production of

acetic acid and ethyl acetate.

The group (b) compound which is used for this step is the same as for the catalyst of the invention (VI).

5 The method of dissolving or suspending the inorganic acid or salt thereof may be any method that produces homogeneity by stirring, etc., and it is not particularly restricted. For example, if it will dissolve it may be dissolved directly in the palladium suspension, and if it does not dissolve, a method may be employed whereby the  
10 inorganic acid or salt thereof is suspended in an appropriate solvent and the palladium suspension is added thereto dropwise.

The method of removing the solvent is not particularly restricted and may be any well-known method  
15 such as heating, pressure reduction, etc. In the case of heating, the temperature is preferably a temperature that does not cause decomposition of the inorganic acid. Particularly in the case of a heteropoly acid, a temperature of higher than 350°C can result in  
20 decomposition, and this may impair the activity and selectivity of the catalyst produced by the method.

In step 2 as well, the metallic palladium starting compound may be subjected to reduction treatment if necessary for conversion to metallic palladium.

25 In the case of reduction treatment in step 2, i.e. conversion to metallic palladium of the metallic palladium starting compound that can be converted to metallic palladium, the method used therefor is not particularly restricted. Specifically there may be  
30 mentioned a method whereby the metallic palladium starting compound is reduced to metallic palladium with an appropriate reducing agent such as hydrazine, formalin, methanol, ethylene, hydrogen or the like. The reduction treatment may be carried out in either a liquid  
35 phase or vapor phase state.

Liquid phase reduction treatment is usually carried out at room temperature, but it may also be conducted



with heating to a higher temperature, for example, about 30-50°C. Vapor phase reduction treatment is preferably carried out with heating to about 100-600°C in order to achieve total conversion to metallic palladium.

5           The procedure for conversion to metallic palladium of the metallic palladium starting compound that can be converted to metallic palladium may be carried out while the metallic palladium starting compound containing (b)  
10           at least one compound selected from the group consisting of inorganic acids and salts thereof is in a suspended solution state, or after separation.

          The catalyst of the invention (VI) can be obtained in the manner described above.

15           Production process (2) according to the invention (XI) will now be explained. Production process (2) according to the invention (XI) is a process for production of a catalyst according to the invention (VII), and it comprises step 1 and step 2 of production process (1) according to the invention (XI), as well as  
20           step 3 in which (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is added in either or both of these steps.

25           The starting compound for the (a) metallic palladium used in step 1 of this process, and the method for its dissolution or suspension, are the same as in step 1 of production process (1) for the catalyst of the invention (VI), according to the invention (XI).

30           The starting material that gives the group (c) element is not particularly restricted, and it may be the element itself or a halide, nitrate, acetate, phosphate, sulfate or oxide containing the element, or even a complex with an organic molecule such as acetyl-acetonato or nitrile as the ligand.

35           Specifically there may be mentioned chlorides such as selenium chloride, tellurium chloride, antimony chloride, tin chloride, bismuth chloride, lead chloride,

etc.; nitrates such as antimony nitrate, tin nitrate, bismuth nitrate, lead nitrate, etc.; acetates such as tin acetate, bismuth acetate, lead acetate, etc.; and selenium oxide, selenic acid ( $\text{H}_2\text{SeO}_4$ ) and its salts, selenious acid ( $\text{H}_2\text{SeO}_3$ ) and its salts, tellurium oxide, telluric acid ( $\text{H}_6\text{TeO}_6$ ) and its salts, tellurous acid ( $\text{H}_2\text{TeO}_3$ ) and its salts, metallic tellurium, potassium antimonate and the like, but there is no limitation to these.

The method of dissolving or suspending the starting compound for the group (c) element, when a group (c) element is added in step 1, may be any method that produces homogeneity by stirring, etc. with the metallic palladium starting compound, and it is not particularly restricted. For example, if it will dissolve it may be dissolved directly together with the starting compound of the metallic palladium, and if it does not dissolve, a method may be employed whereby the starting compound for the group (c) element is suspended in an appropriate solvent and the resulting solution is added dropwise to a solution in which the metallic palladium starting compound has been dissolved or suspended.

The solvent used here may be water or an inorganic or organic solvent such as acetone, ethanol or the like, and, if necessary, an inorganic acid or organic acid such as hydrochloric acid, nitric acid or acetic acid may be dissolved in the solvent that is used. The starting compound for the group (c) element is preferably one that can be homogeneously dissolved or suspended by stirring, etc., but it is not particularly restricted.

When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 1, the method therefor, i.e. the reduction treatment method, is the same as in step 1 of production process (1) according to the invention (XI).

The palladium suspension may be obtained in the

manner described above.

5 The group (b) compound used for step 2 is the same as for the catalyst of the invention (VI), and the method of dissolving or suspending the group (b) compound and the method of removing the solvent are the same as in step 2 of production process (1) according to the invention (XI).

10 When a group (c) element is added in step 2, the starting compound for the element and the method of dissolving or suspending the starting compound for the group (c) element may be the same as in step 1 of production process (2) according to the invention (XI).

15 There are no particular restrictions on the order of adding the group (b) compound and the group (c) element to the palladium suspension, and two or more may be added simultaneously or in any desired order. That is, a group (b) compound and a group (c) element may be added simultaneously, or a group (c) element may be added and separated prior to adding the group (b) compound.

20 When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 2, the method therefor, i.e. the reduction treatment method, is the same as in step 2 of production process (1) according to the invention (XI).

25 The catalyst of the invention (VII) can be obtained in the manner described above.

30 Production process (3) according to the invention (XI) will now be explained. Production process (3) according to the invention (XI) is a process for production of a catalyst according to the invention (VIII), and it comprises step 1 and step 2 of production process (1) according to the invention (XI), as well as step 3 in which (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the

Periodic Table is added in either or both of these steps.

5 The starting compound for the (a) metallic palladium used in step 1 of this process, and the method for its dissolution or suspension, are the same as in step 1 of production process (1) according to the invention (XI).

10 The starting material that gives the group (d) element is not particularly restricted, and it may be the element itself or a halide, nitrate, acetate, phosphate, sulfate or oxide containing the element, or even a complex with an organic molecule such as acetylacetonato or nitrile as the ligand. Specifically there may be mentioned chlorides such as chromium chloride, manganese chloride, rhenium chloride, ruthenium chloride, rhodium chloride, iridium chloride, nickel chloride, tetrachloro  
15 aurate and its salts, zinc chloride and its salts, etc.; nitrates such as chromium nitrate, manganese nitrate, nickel nitrate, iridium nitrate, zinc nitrate, etc.; acetates such as chromium acetate, manganese acetate, rhenium acetate, ruthenium acetate, iridium acetate, nickel acetate, zinc acetate, and the like, but there is  
20 no limitation to these.

The method of dissolving or suspending the starting compound for the group (d) element, when it is added in step 1, may be any method that produces homogeneity by  
25 stirring, etc. with the metallic palladium starting compound, and it is not particularly restricted. For example, if it will dissolve it may be dissolved directly together with the starting compound of the metallic palladium, and if it does not dissolve, a method may be  
30 employed whereby the starting compound for the group (d) element is suspended in an appropriate solvent and the resulting solution is added dropwise to a solution in which the metallic palladium starting compound has been dissolved or suspended.

35 The solvent used here may be water or an inorganic or organic solvent such as acetone, ethanol or the like, and, if necessary, an inorganic acid or organic acid such

as hydrochloric acid, nitric acid or acetic acid may be dissolved in the solvent that is used. The starting compound for the group (d) element is preferably one that can be homogeneously dissolved or suspended by stirring, etc., but it is not particularly restricted.

When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 1, the method therefor, i.e. the reduction treatment method, is the same as in step 1 of production process (1) according to the invention (XI).

The palladium suspension may be obtained in the manner described above.

The group (b) compound used for step 2 is the same as for the catalyst of the invention (VI), and the method of dissolving or suspending the group (b) compound and the method of removing the solvent are the same as in step 2 of production process (1) for the catalyst of the invention (VI), according to the invention (XI).

When a group (d) element is added in step 2, the starting compound for the element and the method of dissolving or suspending the starting compound for the group (d) element may be the same as in step 1 of production process (3).

There are no particular restrictions on the order of adding the group (b) compound and the group (d) element to the palladium suspension, and two or more may be added simultaneously or in any desired order. That is, a group (b) compound and a group (d) element may be added simultaneously, or a group (d) element may be added and separated prior to adding the group (b) compound.

When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 2, the method therefor, i.e. the reduction treatment method, is the same as in step 2 of production process (1) according to the invention (XI).

The catalyst of the invention (VIII) can be obtained in the manner described above.

Production process (4) according to the invention (XI) will now be explained. Production process (4) according to the invention (XI) is a process for production of a catalyst according to the invention (IX), and it comprises step 1 and step 2 of production process (1) according to the invention (XI), as well as step 3 in which (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, are added in either or both of these steps.

The starting compound for the (a) metallic palladium used in step 1 of this process, and the method for its dissolution or suspension, are the same as in step 1 of production process (I) according to the invention (XI).

The starting material that gives the group (c) element, and the method for its dissolution or suspension, are the same as in step 1 of production process (2) according to the invention (XI).

The starting material that gives the group (d) element, and the method for its dissolution or suspension, are the same as in step 1 of production process (3) for a catalyst according to the invention (XI).

When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 1, the method therefor, i.e. the reduction treatment method, is the same as in step 1 of production process (1) according to the invention (XI).

The palladium suspension may be obtained in the manner described above.

The group (b) compound used for step 2 is the same as for the catalyst of the invention (VI), and the method of dissolving or suspending the group (b) compound and the method of removing the solvent are the same as in  
5 step 2 of production process (1) for the catalyst of the invention (VI), according to the invention (XI).

When a group (c) element is added in step 2, the starting compound for the element and the method of dissolving or suspending the starting compound for the  
10 group (c) element may be the same as in step 1 of production process (2) for the catalyst of the invention (VII), according to the invention (XI).

When a group (d) element is added in step 2, the starting compound for the element and the method of dissolving or suspending the starting compound for the  
15 group (d) element may be the same as in step 1 of production process (3) for the catalyst of the invention (VIII), according to the invention (XI).

There are no particular restrictions on the order of adding the group (b) compound and/or the group (c) element and/or the group (d) element to the palladium suspension, and three or more may be added simultaneously or in any desired order. That is, a group (b) compound, a group (c) element and a group (d) element may be added  
20 simultaneously, or a group (b) compound and a group (c) element may be added simultaneously and separated, and then another suspension containing a group (b) compound and a group (c) element may be prepared and a group (d) element added thereto.

When a metallic palladium starting compound that can be converted to metallic palladium is converted to metallic palladium in step 2, the method therefor, i.e. the reduction treatment method, is the same as in step 2 of production process (1) according to the invention  
25 (XI).

The catalyst of the invention (IX) can be obtained in the manner described above.

A process for production of a carrier-held catalyst of the invention (X) according to the invention (XII) will now be explained. The process of the invention (XII) is a process for production of a carrier-held catalyst for production of acetic acid and ethyl acetate according to the invention (X).

Production process (1) for a carrier-held catalyst of the invention (X) according to the invention (XII) comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

Step 1 of production process (1) according to the invention (XII) is a step wherein metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

The metallic palladium starting compound used in step 1 is the same as in step 1 of production process (1) according to the invention (XI).

There are no particular restrictions on the method of loading the metallic palladium, or the metallic palladium starting compound that can be converted to metallic palladium, on the carrier, and the loading may be accomplished by any method. For example, for loading of a metallic palladium starting compound that can be converted to metallic palladium, the loading on the carrier may be accomplished by dissolving or suspending the metallic palladium starting compound in an appropriate solvent such as water or acetone, an inorganic or organic acid such as hydrochloric acid, nitric acid, acetic acid, etc., or a mixture thereof, and



then loading the solution onto the carrier and drying it. For the loading process there may be mentioned means such as the impregnation method, evaporation to dry hardness method, kneading method and spray method, but there is no  
5 limitation to these.

When a metallic palladium starting compound that can be converted to metallic palladium is loaded, the method of subsequently converting the metallic palladium starting compound to metallic palladium, i.e. the  
10 reduction treatment method, is not particularly restricted. The reduction treatment may be carried out in either a liquid phase or vapor phase state, and the conditions are not particularly restricted so long as they are common reducing conditions. Liquid phase  
15 reduction treatment is usually carried out at room temperature, but it may also be conducted with heating to a higher temperature, for example, about 30-50°C. Vapor phase reduction treatment is preferably carried out with heating of the metallic palladium starting compound-  
20 loaded carrier to about 100-600°C in order to achieve total conversion to metallic palladium.

Specifically there may be mentioned a method whereby the metallic palladium starting compound is reduced to metallic palladium using an appropriate reducing agent  
25 such as hydrazine, formalin, hydrogen, methanol, ethylene or the like, either directly or after treatment with an aqueous solution of sodium hydroxide, potassium hydroxide, barium hydroxide, sodium metasilicate, etc. to convert the metallic palladium starting compound to an  
30 oxide, hydroxide, or the like.

The procedure for conversion to metallic palladium of the metallic palladium starting compound that can be converted to metallic palladium may be carried out after separating the catalyst holding the metallic palladium  
35 starting compound, or it may be carried out immediately following the loading procedure. If conditions permit, it is preferably carried out immediately following the

loading procedure, without separation.

If desired, the metallic palladium-loaded catalyst may then be filtered by a common method and then washed and dried to remove out any reaction-inhibiting  
5 substances for the catalytic reaction, such as halides or alkali salts of sodium, etc.

The metallic palladium-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (1) according to the  
10 invention (XII) is a step wherein a catalyst of the invention (X) is obtained by loading (b) at least one compound selected from the group consisting of inorganic acids and salts thereof on the metallic palladium-loaded catalyst obtained in step 1.

15 In step 2, the group (b) compound is the same as for the catalyst of the invention (VI). There are no particular restrictions on the method of loading the group (b) compound, and the loading may be accomplished by any publicly known method. Specifically there may be  
20 mentioned such means as the impregnation method, spray method, evaporation to dry hardness method, kneading method and adsorption method, but there is no limitation to these. The solvent used for impregnation may be any one which can dissolve the inorganic acid, and water,  
25 organic solvents and their mixtures may be used. Water, alcohol and the like are preferably used.

A catalyst of the invention (X) can be obtained in this manner.

30 Production process (2) for a carrier-held catalyst of the invention (X) according to the invention (XII) comprises addition of (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table, in  
35 either or both of steps 1 and 2 of production process (1) according to the invention (XII).

The starting compound for the (a) metallic palladium used in step 1 of production process (2), and the method

for its loading and conversion to metallic palladium, are the same as in step 1 of production process (1) according to the invention (XII).

5 When a group (c) element is added in step 1, the starting compound for the group (c) element is the same as in step 1 of production process (2) according to the invention (XI).

10 There are no particular restrictions on the method of loading the starting compound for the group (c) element on the carrier, and the loading may be accomplished by any method. For example, the starting compound for the group (c) element may be dissolved in an appropriate solvent such as water or acetone, in an inorganic acid or organic acid such as hydrochloric acid, 15 nitric acid, acetic acid, or the like, and then impregnated into the carrier and dried, as the method of loading onto the carrier.

20 The loading method may be any of such means as the impregnation method, evaporation to dry hardness method, kneading method, spray method, or the like, but there is no limitation to these.

25 The loading of the starting compound for the (a) metallic palladium on the carrier and the loading of the starting compound for the group (c) element on the carrier may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other. Preferred and most common is simultaneous loading on the carrier of the starting compound for the group (c) element and the starting compound for the (a) 30 metallic palladium on the carrier.

35 If desired, the metallic palladium-loaded catalyst may then be filtered by a common method and then washed and dried to remove out any reaction-inhibiting substances for the catalytic reaction, such as halides or alkali salts of sodium, etc.

The metallic palladium-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (2) is a step whereby a catalyst of the invention (X) is obtained by loading (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and/or (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table on the metallic palladium-loaded catalyst obtained in step 1.

In step 2, the group (b) compound and the method for its loading are the same as in step 2 of production process (1) according to the invention (XII).

When a group (c) element is loaded in step 2, the starting compound for the group (c) element and the method of its loading are the same as in step 1 of production process (2).

The loading of the group (b) compound on the metallic palladium-loaded catalyst and the loading of the starting compound for the group (c) element on the metallic palladium-loaded catalyst may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other.

A catalyst of the invention (X) can be obtained in the manner described above.

Production process (3) for a carrier-held catalyst of the invention (X) according to the invention (XII) comprises a step of adding (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table in either or both step 1 and step 2 of production process (1) according to the invention (XII).

The starting compound for the (a) metallic palladium used in step 1 of production process (3), and the method for its loading and conversion to metallic palladium, are the same as in step 1 of production process (1) according to the invention (XII).

When a group (d) element is added in step 1, the starting compound for the group (d) element is the same as in step 1 of production process (3) according to the invention (XI).

5        There are no particular restrictions on the method of loading the starting compound for the group (d) element on the carrier, and any method may be employed. For example, the starting compound for the group (d) element may be dissolved in an appropriate solvent such  
10       as water or acetone, in an inorganic acid or organic acid such as hydrochloric acid, nitric acid, acetic acid, or the like, and then impregnated into the carrier and dried, as the method of loading onto the carrier.

15       The loading method may be any of such means as the impregnation method, evaporation to dry hardness method, kneading method, spray method, or the like, but there is no limitation to these.

20       The loading of the starting compound for the (a) metallic palladium on the carrier and the loading of the starting compound for the group (d) element on the carrier may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other. Preferred and most common is simultaneous  
25       loading on the carrier of the starting compound for the group (d) element and the starting compound for the (a) metallic palladium on the carrier.

30       If desired, the metallic palladium-loaded catalyst may then be filtered by a common method and then washed and dried to remove out any reaction-inhibiting substances for the catalytic reaction, such as halides or alkali salts of sodium, etc.

      The metallic palladium-loaded catalyst can be obtained in the manner described above.

35       Step 2 of production process (3) is a process whereby a catalyst of the invention (X) is obtained by loading (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and/or

(d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table on the metallic palladium-loaded catalyst obtained in step 1.

In step 2, the group (b) compound and the method for its loading are the same as in step 2 of production process (1) according to the invention (XII).

When a group (d) element is loaded in step 2, the starting compound for the group (d) element and the method of its loading are the same as in step 1 of production process (3).

The loading of the group (b) compound on the metallic palladium-loaded catalyst and the loading of the starting compound for the group (d) element on the metallic palladium-loaded catalyst may be carried out in any order. That is, both loadings may be carried out simultaneously, or one before the other.

A catalyst of the invention (X) can be obtained in the manner described above.

Production process (4) for a carrier-held catalyst of the invention (X) according to the invention (XII) is a production process used to obtain a catalyst of the invention (IV). The catalyst of the invention (IV) allows production by adding (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table in either or both step 1 and step 2 of production process (1) according to the invention (XII).

In production process (4), the starting compound for the (a) metallic palladium used in step 1, and the method for its loading and conversion to metallic palladium, are

the same as in step 1 of production process (1) according to the invention (XII).

When a group (c) element is added in step 1, the starting compound for the group (c) element and the method for its loading are the same as in step 1 of production process (2) according to the invention (XII).

When a group (d) element is added, the starting compound for the group (d) element and the method for its loading are the same as in step 1 of production process (3) according to the invention (XII).

The loading of the starting compound for the (a) metallic palladium on the carrier and the loading of the starting compound for the group (c) element and/or the starting compound for the group (d) element on the carrier may be carried out in any order. That is, all three loadings may be carried out simultaneously, or any one before the others. Preferred and most common is loading on the carrier of the starting compound for the group (c) element and the starting compound for the group (d) element simultaneously with the starting compound for the (a) metallic palladium.

If desired, the metallic palladium-loaded catalyst may then be filtered by a common method and then washed and dried to remove out any reaction-inhibiting substances for the catalytic reaction, such as halides or alkali salts of sodium, etc.

The metallic palladium-loaded catalyst can be obtained in the manner described above.

Step 2 of production process (4) is a process whereby a catalyst of the invention (X) is obtained by loading (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and/or (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and/or (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements,

Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table on the metallic palladium-loaded catalyst obtained in step 1.

5 In step 2, the group (b) compound and the method for its loading are the same as in step 2 of production process (1) according to the invention (XII).

10 When a group (c) element is loaded in step 2, the starting compound for the group (c) element and the method for its loading are the same as in step 1 of production process (2) according to the invention (XII).

When a group (d) element is loaded in step 2, the starting compound for the group (d) element and the method for its loading are the same as in step 1 of production process (3) according to the invention (XII).

15 In step 2, the loading of the group (b) compound on the metallic palladium-loaded catalyst and/or the loading of the starting compound for the group (c) element and/or the starting compound for the group (d) element on the metallic palladium-loaded catalyst may be carried out in any order. That is, the loadings may be carried out simultaneously, or any one before the others.

20 A catalyst of the invention (X) can be obtained in the manner described above.

25 The process for production of acetic acid and ethyl acetate according to the invention (XIII) will now be explained. The invention (XIII) is a process for production of acetic acid and ethyl acetate from ethanol and oxygen using a catalyst according to any one of the inventions (VI) to (X).

30 The reaction process is not particularly restricted so long as it allows the catalyst of the invention to react ethanol with oxygen, and it may be any of a variety of processes including a batch process, semi-batch process, semi-continuous process, continuous flow process or a combination thereof, for a vapor phase reaction and/or liquid phase reaction.

35 The ethanol starting material may be supplied in



liquid form, or it may be supplied in vapor form. That is, the reaction process may be, for example, a semi-continuous process whereby the catalyst of the invention is suspended in liquid ethanol and/or an ethanol solution and oxygen is passed through, or a continuous flow process whereby ethanol and oxygen gas are passed through the catalyst. A vapor phase continuous flow process is preferred from the standpoint of separation of the catalyst, starting materials and products, and the standpoint of productivity. More preferred, and advantageous in practical terms, is to employ a fixed bed having corrosion-resistant reaction tubes packed with the catalyst of the invention, for a vapor phase reaction in which the ethanol and oxygen are passed through.

A vapor phase reaction and liquid phase reaction used for production of acetic acid and ethyl acetate according to the invention (XIII) will now be explained.

A vapor phase reaction will be explained first.

There are no particular restrictions on the reaction temperature for the reaction of ethanol and oxygen in a vapor phase according to the acetic acid and ethyl acetate production method of the invention (XIII), but it is preferably 100-250°C. If the reaction temperature is below 100°C the reaction rate may be insufficient, while if it is above 250°C a greater number of secondary reactions will tend to occur. More preferred in practical terms is the range of 110-230°C.

In terms of the equipment, it is advantageous in practice for the reaction pressure to be from 0.0 to 3.0 MPa (gauge pressure), and more preferably in the range of 0.1 to 1.5 MPa (gauge pressure).

In the case of a flow-type reaction, the gas supplied to the reaction system comprises ethanol and oxygen, and if necessary nitrogen, carbon dioxide, a rare gas or the like may also be used as a diluent. The ethanol is supplied to the reaction system in an amount corresponding to a proportion of 0.1-50% by volume, and

especially 0.5-40% by volume, and the oxygen in an amount corresponding to a proportion of 1-15% by volume, and especially 2-10% by volume, with respect to the total amount of supply gas. Here, a high concentration of ethanol in the supply gas will result in greater production of ethyl acetate, while a lower concentration will tend to result in higher selectivity for acetic acid. An ethanol concentration exceeding 50% by volume will tend to increase the number of secondary reactions, while a concentration of under 0.1% by volume will tend to lower the productivity.

The presence of water in the reaction system will provide a notable effect of improved acetic acid and ethyl acetate production activity and selectivity, as well as prolonged activity of the catalyst in the reaction system. It is suitable for water vapor to be included in the reaction gas at 0.1-50% by volume. If the water vapor in the reaction gas is present at less than 0.1% by volume the catalyst may tend to undergo deterioration more readily, and if it is present at greater than 50% by volume, the steam unit requirement may be poorer. In practical terms, the range is preferably 0.5-40% by volume.

When carrying out the process of the invention (XIII) by this gas phase reaction it is advantageous to use a high purity ethanol starting material, but there is no problem with mixing a small amount of a lower saturated hydrocarbon such as methane, ethane or propane, or acetaldehyde, diethyl ether, ethylene or the like. In particular, acetaldehyde, diethyl ether and ethylene that are trace by-products of this reaction can be converted to acetic acid and/or ethyl acetate by a catalyst of the invention. The oxygen can also be in a form such as air, diluted with an inert gas such as nitrogen, carbon dioxide gas or the like, but when the reaction gas is circulated it is generally more advantageous to use oxygen at a high concentration, preferably 99% or

greater. The reaction mixture gas is preferably passed through the catalyst at a space velocity (SV) in the range of 500-15,000 hr<sup>-1</sup>, and especially 1000-10,000 hr<sup>-1</sup>, in a standard state.

5           Next, a liquid phase reaction will be explained.

          There are no particular restrictions on the reaction temperature for the reaction of ethanol and oxygen in a liquid phase according to the acetic acid and ethyl acetate production method of the invention (XIII), but it is preferably 0-200°C. If the reaction temperature is 10 below 0°C the reaction rate may be insufficient, while if it is above 200°C a greater number of secondary reactions will tend to occur. More preferred in practical terms is the range of 20-110°C.

15           In terms of the equipment, it is advantageous in practice for the reaction pressure to be from 0.0 to 3.0 MPa (gauge pressure), and more preferably in the range of 0.1 to 1.5 MPa (gauge pressure).

          The ethanol and/or oxygen starting materials may be 20 present in the catalyst beforehand, or they may be added at an appropriate point during the reaction. When they are supplied to the reaction system, they may be in gaseous and/or liquid form. The starting material supplied to the reaction system comprises ethanol and 25 oxygen, and if necessary nitrogen, carbon dioxide or a diluting gas may also be used.

          The presence of water in the reaction system will provide a notable effect of improved acetic acid and ethyl acetate production activity and selectivity, as 30 well as prolonged activity of the catalyst in the reaction system. The proportion of water and ethanol in the reaction system is not particularly restricted. The proportion of water and ethanol may even be changed during the reaction, or an appropriate amount of water 35 may be added to keep a constant proportion. If desired, a basic component such as sodium hydroxide may be added to increase the reaction rate.

When carrying out the invention (XIII) by this liquid phase reaction it is advantageous to use a high purity ethanol starting material, but there is no problem with mixing a small amount of a lower saturated hydrocarbon such as methane, ethane or propane, or acetaldehyde, diethyl ether, ethylene or the like. In particular, acetaldehyde, diethyl ether and ethylene that are trace by-products of this reaction can be converted to acetic acid and/or ethyl acetate by a catalyst of the invention. The oxygen can also be in a form such as air, diluted with an inert gas such as nitrogen, carbon dioxide gas or the like, but when the reaction gas is circulated it is generally more advantageous to use oxygen at a high concentration, preferably 99% or greater.

Production of acetic acid and ethyl acetate according to the invention (XIII) in this manner allows acetic acid and ethyl acetate to be obtained with high activity and high selectivity from ethanol and oxygen. The acetic acid and ethyl acetate obtained may be separated and purified by common methods, to the desired degree of purity. When unreacted starting materials and by-products of acetaldehyde, diethyl ether and ethylene remain, those unreacted starting materials and by-products of acetaldehyde, diethyl ether and ethylene can be recovered and recycled into the reaction system for use.

When either acetic acid or ethyl acetate is required for industrial use, it may be separated and removed after the reaction to obtain the desired substance, and the other product returned to the reaction system. For example, if ethyl acetate is required, the desired ethyl acetate may be separated and recovered after the reaction and the acetic acid returned to the reaction system, to obtain additional ethyl acetate from acetic acid and ethanol.

When necessary, the catalyst used may be regenerated

at an appropriate point or separated for repeated used.

The present invention will now be explained in greater detail by way of the following examples, which are only generally illustrative of the invention and are not intended to restrict it in any way.

All of the carriers used in the following examples were dried in air at 110°C for 4 hours, as pretreatment. The water used in the examples was deionized water.

#### Example 1

A silica carrier [KA-1, particle size: 5 mmφ, product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate [Na<sub>2</sub>PdCl<sub>4</sub>, product of Tanaka Kikinzoku] (1.90 g) and telluric acid [H<sub>6</sub>TeO<sub>6</sub>, product of Kanto Chemical Co.] (0.13 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate [Na<sub>2</sub>SiO<sub>3</sub>·9H<sub>2</sub>O, product of Wako Junyaku] (5.5 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate [N<sub>2</sub>H<sub>4</sub>·H<sub>2</sub>O, product of Wako Junyaku] (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours at a rate of about 1.5 liters per hour for washing. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 1.

#### Example 2

Acetic acid production catalyst 2 was obtained by the same procedure as Example 1, except that lead acetate trihydrate [(CH<sub>3</sub>COO)<sub>2</sub>Pb, product of Wako Junyaku] (0.74 g) was used instead of the telluric acid in Example 1.

#### Example 3

A silica carrier [KA-1, particle size: 5 mmφ,

product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (1.90 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (5.5 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours at a rate of about 1.5 liters per hour for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then added to an aqueous solution (45 ml) of sodium tellurite [ $\text{Na}_2\text{TeO}_3$ , product of Wako Junyaku] (0.12 g) to absorb the entire amount. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 3.

#### Example 4

Acetic acid production catalyst 4 was obtained by the same procedure as Example 3, except that an acetic acid solution of bismuth nitrate pentahydrate [ $\text{Bi}(\text{NO}_3)_3 \cdot 5\text{H}_2\text{O}$ , product of Wako Junyaku] (0.37 g) was used instead of the sodium tellurite in Example 3.

#### Example 5

Acetic acid production catalyst 5 was obtained by the same procedure as Example 3, except that an acetic acid solution of tin acetate [ $\text{CH}_3(\text{COO})_2\text{Sn}$ , product of Wako Junyaku] (0.26 g) was used instead of the sodium tellurite in Example 3.

#### Example 6

A silica carrier [CARiACT, Q-10, product of Fuji Silicia Chemical Co.] (57 g) was added to an aqueous solution (56 ml) of sodium tetrachloropalladate (1.90 g),

to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (6.0 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding  
5 hydrazine monohydrate (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock  
10 and purified water was passed through for 40 hours at a rate of about 1.5 liters per hour for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then  
15 added to an aqueous solution (55 ml) of sodium tellurite (0.12 g) to absorb the entire amount. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 6.

#### Example 7

20 A titania carrier [CS-300S-46, particle size: 3-5 mmφ, product of Sakai Chemical Industries] (107 g) was added to an aqueous solution (42 ml) of sodium tetrachloropalladate (1.90 g), to absorb the entire amount. This was then added to an aqueous solution (100  
25 ml) of sodium metasilicate nonahydrate (6.0 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to  
30 metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours at a rate of about 1.5 liters per hour for washing. This was then dried for 4 hours  
35 under an air stream at 110°C to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then

added to an aqueous solution (42 ml) of sodium tellurite (0.12 g) to absorb the entire amount. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 7.

5           Example 8

          A silica carrier [KA-1, particle size: 5 mmφ, product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (1.90 g) and tetrachloro aurate tetrahydrate [ $\text{H}_4\text{AuCl}_4 \cdot 4\text{H}_2\text{O}$ , product of Tanaka Kikinzoku] (0.50 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (6.9 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (6.5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours at a rate of about 1.5 liters per hour for washing. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 8.

          Example 9

25           Acetic acid production catalyst 9 was obtained by the same procedure as Example 8, except that zinc chloride [ $\text{ZnCl}_2$ , product of Wako Junyaku] (0.08 g) was used instead of the tetrachloro aurate tetrahydrate in Example 8.

30           Example 10

          Acetic acid production catalyst 10 was obtained by the same procedure as Example 8, except that chromium chloride hexahydrate [ $\text{CrCl}_3 \cdot 6\text{H}_2\text{O}$ , product of Wako Junyaku] (0.22 g) was used instead of the tetrachloro aurate tetrahydrate in Example 8.

35           Example 11

          Acetic acid production catalyst 11 was obtained by



the same procedure as Example 8, except that manganese chloride tetrahydrate [ $\text{MnCl}_2 \cdot 4\text{H}_2\text{O}$ , product of Wako Junyaku] (0.23 g) was used instead of the tetrachloro aurate tetrahydrate in Example 8.

5           Example 12

A silica carrier [KA-1, particle size: 5 mm $\phi$ , product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (1.90 g) and tetrachloro aurate tetrahydrate (0.50 g), to absorb  
10 the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (6.9 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (6.5 g) thereto and gently stirring, the  
15 mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours at a  
20 rate of about 1.5 liters per hour for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst containing gold.

This metallic palladium-loaded catalyst was then  
25 added to an aqueous solution (45 ml) of sodium tellurite (0.12 g), to absorb the entire amount. It was then dried for 4 hours under an air stream at 110°C to obtain acetic acid production catalyst 12.

          Example 13

30           Acetic acid production catalyst 13 was obtained by the same procedure as Example 12, except that zinc chloride (0.08 g) was used instead of the tetrachloro aurate in Example 12.

          Example 14

35           Acetic acid production catalyst 14 was obtained by the same procedure as Example 12, except that chromium chloride hexahydrate (0.22 g) was used instead of the

tetrachloro aurate in Example 12.

Comparative Example 1

5 A silica carrier [KA-1, particle size: 5 mm $\phi$ ,  
product of Züd-chemie AG] (69 g) was added to an aqueous  
solution (45 ml) of sodium tetrachloropalladate (1.90 g)  
to absorb the entire amount. This was then added to an  
aqueous solution (100 ml) of sodium metasilicate  
nonahydrate (5.5 g), and the mixture was allowed to stand  
at room temperature for 20 hours. After then adding  
10 hydrazine monohydrate (5 g) thereto and gently stirring,  
the mixture was allowed to stand at room temperature for  
4 hours for reduction to metallic palladium. After  
filtering the catalyst and performing decantation, it was  
transferred to a glass column equipped with a stopcock  
15 and purified water was passed through for 40 hours at a  
rate of about 1.5 liters per hour for washing. This was  
then dried for 4 hours under an air stream at 110°C to  
obtain acetic acid production catalyst 15.

Elemental analysis of acetic acid production catalysts

20 Acetic acid production catalysts containing (a)  
palladium, a group (b) element and/or a group (c) element  
were subjected to heat treatment using aqua regia and/or  
a mixture of hydrofluoric acid and aqua regia for  
complete extraction of each of the components, and  
25 measurement was performed by inductively coupled plasma  
(ICP) emission spectroscopy. The ICP emission  
spectroscopy used was an SPS-1700 by Seiko Denshi Kogyo,  
KK.

30 The weight ratios for each of the components in  
catalysts 1-15 obtained in Examples 1-14 and Comparative  
Example 1 and the molar ratios with respect to Pd for  
each of the components are shown in Table 1. The  
percentage values in the table represent weight  
percentages with respect to each catalyst.

Table 1

Catalyst No.	Catalyst component (a)	Catalyst component (b)	Catalyst component (c)
Catalyst 1	Pd 0.86%	Te (tellurium) 0.091% (Te/Pd=0.09)	
Catalyst 2	Pd 0.86%	Pb (lead) 0.54% (Pb/Pd=0.33)	
Catalyst 3	Pd 0.86%	Te (tellurium) 0.091% (Te/Pd=0.09)	
Catalyst 4	Pd 0.86%	Bi (bismuth) 0.198% (Bi/Pd=0.12)	
Catalyst 5	Pd 0.86%	Sn (tin) 0.180% (Sn/Pd=0.19)	
Catalyst 6	Pd 1.11%	Te (tellurium) 0.117% (Te/Pd=0.09)	
Catalyst 7	Pd 0.59%	Te (tellurium) 0.062% (Te/Pd=0.09)	
Catalyst 8	Pd 0.86%		Au (gold) 0.30% (Au/Pd=0.19)
Catalyst 9	Pd 0.86%		Zn (zinc) 0.10% (Zn/Pd=0.10)
Catalyst 10	Pd 0.86%		Cr (chromium) 0.07% (Cr/Pd=0.14)
Catalyst 11	Pd 0.86%		Mn (manganese) 0.088% (Mn/Pd=0.20)
Catalyst 12	Pd 0.86%	Te (tellurium) 0.091% (Te/Pd=0.09)	Au (gold) 0.30% (Au/Pd=0.19)
Catalyst 13	Pd 0.86%	Te (tellurium) 0.091% (Te/Pd=0.09)	Zn (zinc) 0.10% (Zn/Pd=0.10)
Catalyst 14	Pd 0.86%	Te (tellurium) 0.091% (Te/Pd=0.09)	Cr (chromium) 0.09% (Cr/Pd=0.15)
Catalyst 15	Pd 0.86%		

5 Examples 15-28 and Comparative Example 2 [Production of acetic acid]

An SUS316 reaction tube (25 mm inner diameter) was packed with 12.5 ml of each of the acetic acid production

catalysts obtained in Examples 1-14 and Comparative Example 1, and reaction was conducted with a catalyst bed reaction peak temperature of 160°C, a reaction pressure of 0.8 MPa (gauge pressure), introduction of a gas supply comprising a mixture of ethanol, oxygen, steam and nitrogen at a volume ratio of 2.5:6:25:66.5 and a space velocity of 4400 hr<sup>-1</sup>. The gas produced was cooled, and the condensed reaction solution that was collected was analyzed by gas chromatography (GC-14B, FID by Shimadzu Kagaku, KK.).

The activity of each catalyst was calculated as the grams of acetic acid produced per hour per liter of catalyst (space time yield, STY), and the selectivity was calculated as the percentage of product with respect to the starting ethanol.

The reaction results are shown in Table 2.

Table 2

Ex. No.	Catalyst	Composition	STY acetic acid g/hlcat	Ethanol conversion rate %	Acetic acid selectivity %	Ethyl acetate %	Acet-aldehyde %	CO <sub>2</sub> %
Example								
15	1	Pd-Te	193	79	83	12	0.7	2.2
16	2	Pd-Pb	186	70	90	11	1.0	1.8
17	3	Pd-Te	198	80	84	11	1.0	1.8
18	4	Pd-Bi	184	80	78	12	2.3	5.6
19	5	Pd-Sn	163	73	76	12	2.3	8.6
20	6	Pd-Te	203	82	84	11	0.8	3.0
21	7	Pd-Te	138	72	65	20	2.0	8.0
22	8	Pd-Au	183	83	75	14	2.0	8.2
23	9	Pd-Zn	159	75	72	13	2.3	12.1
24	10	Pd-Cr	142	72	70	12	2.4	14.3
25	11	Pd-Mn	168	80	74	12	0.4	10.3
26	12	Pd-Te-Au	220	88	85	5	1.0	3.0
27	13	Pd-Te-Zn	244	90	92	3	1.4	3.1
28	14	Pd-Te-Cr	226	89	90	4	1.2	4.1
Comp. Ex. 2	15	Pd alone	120	54	63	7	4.5	25.0

#### Example 29

A silica carrier [KA-1, particle size: 5 mmφ, product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate [Na<sub>2</sub>PdCl<sub>4</sub>, product of Tanaka Kikinzoku] (1.90 g), to absorb the entire amount. This was then added to an

aqueous solution (100 ml) of sodium metasilicate nonahydrate [ $\text{Na}_2\text{SiO}_3 \cdot 9\text{H}_2\text{O}$ , product of Wako Junyaku] (3.8 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate [ $\text{N}_2\text{H}_4 \cdot \text{H}_2\text{O}$ ] (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at  $110^\circ\text{C}$  to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then impregnated with an aqueous solution (45 ml) of tungstosilicic acid n-hydrate ( $\text{H}_4\text{SiW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ :  $n=20-30$ , product of Nihon Muki Kagaku Kogyo) (44 g). The addition was performed all at once, and the mixture was gently stirred by rotation until the solution was thoroughly absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at  $110^\circ\text{C}$ , it was allowed to stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 1.

#### Example 30

Acetic acid and ethyl acetate production catalyst 2 was obtained by the same procedure as Example 29, except that tungstophosphoric acid n-hydrate ( $\text{H}_3\text{PW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ :  $n=20-30$ , product of Nihon Muki Kagaku Kogyo) (59 g) was used instead of the tungstosilicic acid n-hydrate in Example 29.

#### Example 31

Acetic acid and ethyl acetate production catalyst 3 was obtained by the same procedure as Example 29, except that an aqueous solution (45 ml) of manganese tungstosilicate was used instead of the tungstosilicic

acid n-hydrate in Example 29.

The manganese tungstosilicate aqueous solution was obtained by dissolving manganese nitrate hexahydrate [ $\text{Mn}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$ , product of Wako Junyaku] (0.38 g) in an aqueous solution of tungstosilicic acid n-hydrate (44 g).

Example 32

Acetic acid and ethyl acetate production catalyst 4 was obtained by the same procedure as Example 29, except that an aqueous solution (45 ml) of copper tungstosilicate was used instead of the tungstosilicic acid n-hydrate in Example 29.

The copper tungstosilicate aqueous solution was obtained by dissolving copper nitrate trihydrate [ $\text{Cu}(\text{NO}_3)_2 \cdot 3\text{H}_2\text{O}$ , product of Wako Junyaku] (0.32 g) in an aqueous solution of tungstosilicic acid n-hydrate (44 g).

Example 33

A silica carrier [CARIACT, Q-15, product of Fuji Silicia Kagaku] (55 g) was added to an aqueous solution (56 ml) of sodium tetrachloropalladate (1.90 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (4.0 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at  $110^\circ\text{C}$  to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then impregnated with an aqueous solution (56 ml) of tungstophosphoric acid n-hydrate ( $\text{H}_3\text{PW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ ;  $n=20-30$ , product of Nihon Muki Kagaku Kogyo) (45 g). The addition was performed all at once, and the mixture was gently

stirred by rotation until the solution was thoroughly absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at 110°C, it was allowed to stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 5.

#### Example 34

A silica carrier [KA-1, particle size: 5 mmφ, product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate [Na<sub>2</sub>PdCl<sub>4</sub>, product of Tanaka Kikinzoku] (1.90 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate [Na<sub>2</sub>SiO<sub>3</sub>·9H<sub>2</sub>O, product of Wako Junyaku] (3.8 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate [N<sub>2</sub>H<sub>4</sub>·H<sub>2</sub>O] (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then impregnated with an aqueous solution (45 ml) of tungstosilicic acid n-hydrate (H<sub>4</sub>SiW<sub>12</sub>O<sub>40</sub>·nH<sub>2</sub>O: n=20-30, product of Nihon Muki Kagaku Kogyo) (44 g) and telluric acid [H<sub>6</sub>TeO<sub>6</sub>, product of Kanto Kagaku] (0.13 g). The addition was performed all at once, and the mixture was gently stirred by rotation until the solution was thoroughly absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at 110°C, it was

allowed to stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 6.

Example 35

5 Acetic acid and ethyl acetate production catalyst 7 was obtained by the same procedure as Example 34, except that bismuth nitrate pentahydrate  $[\text{Bi}(\text{NO}_3)_3 \cdot 5\text{H}_2\text{O}]$ , product of Wako Junyaku (0.40 g) was used instead of the telluric acid in Example 34.

10 Example 36

A silica carrier [KA-1, particle size: 5 mm $\phi$ , product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (1.90 g) and tetrachloro aurate tetrahydrate  $[\text{H}_4\text{AuCl}_4 \cdot 4\text{H}_2\text{O}]$ , product of Tanaka Kikinzoku (0.50 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (5.2 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (6.5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst.

This metallic palladium-loaded catalyst was then impregnated with an aqueous solution (45 ml) of tungstosilicic acid n-hydrate  $(\text{H}_4\text{SiW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}; n=20-30)$ , product of Nihon Muki Kagaku Kogyo (44 g). The addition was performed all at once, and the mixture was gently stirred by rotation until the solution was thoroughly absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at 110°C, it was allowed to



stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 8.

Example 37

5 Acetic acid and ethyl acetate production catalyst 9 was obtained by the same procedure as Example 36, except that zinc chloride [ $\text{ZnCl}_2$ , product of Wako Junyaku] (0.08 g) was used instead of the tetrachloro aurate tetrahydrate in Example 36.

Example 38

10 A silica carrier [KA-1, particle size: 5 mm $\phi$ , product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (3.80 g) and zinc chloride (0.14 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of  
15 sodium metasilicate nonahydrate (8.1 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (6.5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic  
20 palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a  
25 metallic palladium-loaded catalyst containing zinc.

This metallic palladium-loaded catalyst was then added to an aqueous solution (45 ml) of sodium tellurite (0.27 g), to absorb the entire amount. It was then dried for 4 hours under an air stream at 110°C to obtain a  
30 metallic palladium-loaded catalyst containing tellurium and zinc.

This metallic palladium-loaded catalyst was then impregnated with an aqueous solution (45 ml) of tungstosilicic acid n-hydrate ( $\text{H}_4\text{SiW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ :  $n=20-30$ ,  
35 product of Nihon Muki Kagaku Kogyo) (24 g). The addition was performed all at once, and the mixture was gently stirred by rotation until the solution was thoroughly

absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at 110°C, it was allowed to stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 10.

#### Example 39

A silica carrier [KA-1, particle size: 5 mmφ, product of Züd-chemie AG] (69 g) was added to an aqueous solution (45 ml) of sodium tetrachloropalladate (2.76 g) and tetrachloro aurate tetrahydrate (0.78 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium metasilicate nonahydrate (8.3 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (6.5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at 110°C to obtain a metallic palladium-loaded catalyst containing gold.

This gold-containing metallic palladium-loaded catalyst was then impregnated with an aqueous solution (45 ml) of tungstosilicic acid n-hydrate ( $\text{H}_4\text{SiW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ ;  $n=20-30$ , product of Nihon Muki Kagaku Kogyo) (24 g) and telluric acid (0.28 g). The addition was performed all at once, and the mixture was slowly stirred by rotation until the solution was thoroughly absorbed (about 3 minutes). After impregnation, the wet impregnated carrier was allowed to stand at room temperature for one hour. After drying in an oven for 4 hours under an air stream at 110°C, it was allowed to stand overnight in a dessicator. This produced acetic acid and ethyl acetate production catalyst 11.

## Example 40

Tungstophosphoric acid n-hydrate ( $\text{H}_3\text{PW}_{12}\text{O}_{40} \cdot n\text{H}_2\text{O}$ :  
n=20-30, product of Nihon Muki Kagaku Kogyo) (150 g) was  
dissolved in water (75 ml) to obtain a tungstophosphoric  
acid aqueous solution. An aqueous solution (160 ml) of  
5 cesium nitrate [ $\text{CsNO}_3$ , product of Wako Junyaku] (25 g)  
was added dropwise over 5 minutes using a dropping funnel  
while vigorously stirring the tungstophosphoric acid  
aqueous solution, to obtain a cesium tungstophosphate  
10 slurry-like precipitate. The slurry-like precipitate was  
vigorously stirred while an acetone solution (10 ml) of  
palladium acetate [ $\text{Pd}(\text{OAc})_2$ ] (11.7 g) was added dropwise  
over 5 minutes using a dropping funnel, and then the  
mixture was stirred for one hour. The solvent was then  
15 effluxed off with a rotary evaporator, the precipitate  
was removed, and this precipitate was dried for 3 hours  
in an oven under an air stream at  $150^\circ\text{C}$ . The resulting  
palladium-containing cesium tungstophosphate salt was  
pulverized to a particle size of 3-5 mm, dried for 3  
20 hours under an air stream at  $200^\circ\text{C}$  and subjected to 5  
hours of reduction treatment by a hydrogen stream at  
 $250^\circ\text{C}$ , to obtain acetic acid and ethyl acetate production  
catalyst 12

## Comparative Example 3

25 A silica carrier [KA-1, particle size: 5 mm $\phi$ ,  
product of Züd-chemie AG] (69 g) was added to an aqueous  
solution (45 ml) of sodium tetrachloropalladate (1.90 g),  
to absorb the entire amount. This was then added to an  
aqueous solution (100 ml) of sodium metasilicate  
30 nonahydrate (5.5 g), and the mixture was allowed to stand  
at room temperature for 20 hours. After then adding  
hydrazine monohydrate (5 g) thereto and gently stirring,  
the mixture was allowed to stand at room temperature for  
4 hours for reduction to metallic palladium. After  
35 filtering the catalyst and performing decantation, it was  
transferred to a glass column equipped with a stopcock  
and purified water was passed through for 40 hours for

washing. This was then dried for 4 hours under an air stream at 110°C to obtain acetic acid and ethyl acetate production catalyst 13.

#### Comparative Example 4

5 A  $\gamma$ -alumina carrier [NST-3, particle size: 3.2 mm $\phi$ , product of Nikki Universal] (50 g) was added to an aqueous solution (30 ml) of sodium tetrachloropalladate (1.90 g), to absorb the entire amount. This was then added to an aqueous solution (100 ml) of sodium  
10 metasilicate nonahydrate (5.5 g), and the mixture was allowed to stand at room temperature for 20 hours. After then adding hydrazine monohydrate (5 g) thereto and gently stirring, the mixture was allowed to stand at room temperature for 4 hours for reduction to metallic  
15 palladium. After filtering the catalyst and performing decantation, it was transferred to a glass column equipped with a stopcock and purified water was passed through for 40 hours for washing. This was then dried for 4 hours under an air stream at 110°C to obtain acetic  
20 acid and ethyl acetate production catalyst 14.

#### Elemental analysis of acetic acid and ethyl acetate production catalysts

Catalysts containing (a) metallic palladium, (b) an inorganic acid and/or salt thereof and/or a group (c)  
25 element and/or a group (d) element were subjected to heat treatment using aqua regia and/or a mixture of hydrofluoric acid and aqua regia for complete extraction of each of the components, and measurement was performed by inductively coupled plasma (ICP) emission  
30 spectroscopy. The ICP emission spectroscope used was an SPS-1700 by Seiko Denshi Kogyo, KK.

The weight ratios for each of the components in acetic acid and ethyl acetate production catalysts 1 to 14 obtained in Examples 29-40 and Comparative Examples 3  
35 and 4 are shown in Table 3. The percentage values in the tables represent weight percentages with respect to each catalyst. The weight percentages of the heteropoly acids

are expressed in terms of the values calculated for the molecular weight of each corresponding anhydride. For the group (c) elements and the group (d) elements in Table 3, the molar ratios of each element with respect to elemental Pd are shown in parentheses.

5

Table 3

Production catalyst	Catalyst component (a)	Catalyst component (b)	Catalyst component (c)	Catalyst component (d)
Catalyst 1	Pd 0.58%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 32.2%	-	-
Catalyst 2	Pd 0.60%	tungstophosphoric acid ( $H_3PW_{12}O_{40}$ ) 33.8%	-	-
Catalyst 3	Pd 0.58%	manganese salt of tungstosilicic acid 33.0% ( $Mn_{0.1}H_{3.6}SiW_{12}O_{40}$ )	-	-
Catalyst 4	Pd 0.60%	copper salt of tungstosilicic acid ( $Cu_{0.1}H_{2.8}PW_{12}O_{40}$ ) 34.3%	-	-
Catalyst 5	Pd 0.63%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 42.2%	-	-
Catalyst 6	Pd 0.57%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 33.0%	Te (tellurium) 0.11% (Te/Pd=0.09)	-
Catalyst 7	Pd 0.57%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 33.3%	Bi (bismuth) 0.23% (Bi/Pd=0.12)	-
Catalyst 8	Pd 0.57%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 32.1%	-	Au (gold) 0.20% (Au/Pd=0.19)
Catalyst 9	Pd 0.57%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 31.8%	-	Zn (zinc) 0.03% (Zn/Pd=0.10)
Catalyst 10	Pd 1.46%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 22.4%	Te (tellurium) 0.062% (Te/Pd=0.09)	Zn (zinc) 0.10% (Zn/Pd=0.10)
Catalyst 11	Pd 1.06%	tungstosilicic acid ( $H_4SiW_{12}O_{40}$ ) 24.4%	Te (tellurium) 0.063% (Te/Pd=0.11)	Au (gold) 0.40% (Au/Pd=0.19)
Catalyst 12	Pd 3.6%	cesium salt of tungstophosphoric acid 96.0% ( $Cs_{2.5}H_{3.5}PW_{12}O_{40}$ )	-	-
Catalyst 13	Pd 0.58%	-	-	-
Catalyst 14	Pd 1.10%	-	-	-

5 Examples 41-52 and Comparative Examples 5 and 6  
[Production of acetic acid and ethyl acetate]

An SUS316 reaction tube (25 mm inner diameter) was packed with 25.0 ml of each of the acetic acid and ethyl acetate production catalysts obtained in Examples 29-40 and Comparative Examples 3 and 4, and reaction was conducted with a catalyst bed reaction peak temperature of 160°C, a reaction pressure of 0.8 MPa (gauge pressure), introduction of a gas supply comprising a mixture of ethanol, oxygen, steam and nitrogen at a volume ratio of 10:6:25:59 and a space velocity of 1800 hr<sup>-1</sup>. The gas produced was cooled, and the condensed reaction solution that was collected and its gas components were analyzed by gas chromatography (GC-14B by Shimadzu Kagaku, KK., FID and TCD).

The activity of each catalyst was calculated as the grams of acetic acid and ethyl acetate produced per hour per liter of catalyst (space time yield, STY/unit g/h·lcat), and the selectivity was calculated as the percentage of product with respect to the starting ethanol.

The reaction results are shown in Table 4.

Table 4

Ex. No.	Production catalyst	STY (g/h·lcat)		Conversion rate (%)	Selectivity(%)					
		Ethyl acetate	Acetic acid		Ethyl acetate	Acetic acid	CO <sub>2</sub> *	Acet-aldehyde	Diethyl ether	Ethylene
Ex.										
41	1	172	45	63	78	15	2.3	3.3	1.7	0.2
42	2	177	50	65	77	16	3.5	2.1	1.0	0.2
43	3	170	53	65	74	17	3.0	3.2	2.0	0.2
44	4	170	16	60	80	11	2.9	3.2	2.0	0.2
45	5	182	38	66	78	12	3.3	3.5	1.5	0.5
46	6	121	25	51	67	10	0.7	4.4	13.0	1.8
47	7	124	29	50	70	12	1.0	3.1	13.0	1.0
48	8	193	47	70	78	14	2.0	1.3	1.6	1.5
49	9	212	43	75	80	12	2.3	2.8	1.5	0.5
50	10	177	121	81	62	31	1.3	0.4	1.1	4.2
51	11	189	119	85	63	28	1.2	0.4	1.0	3.8
52	12	69	66	40	49	34	5.3	5.3	2.3	3.3
Comp. Ex.										
5	13	30	108	49	21	56	15	8.0	0.0	0.3
6	14	42	32	30	40	22	20	10.2	6.0	2.3

\*CO<sub>2</sub>: carbon dioxide

Examples 53-56 [Production of acetic acid and ethyl acetate]

An SUS316 reaction tube (25 mm inner diameter) was packed with acetic acid and ethyl acetate production catalyst 10 obtained in Example 38 (25.0 ml), and reaction was conducted with a catalyst bed reaction peak temperature of 160°C, a reaction pressure of 0.8 MPa (gauge pressure), introduction of a gas supply comprising a mixture of ethanol, oxygen, steam and nitrogen at a volume ratio (%) of X:6:25:(69-X) and a space velocity of 1800 hr<sup>-1</sup>. The ethanol gas concentrations (X%) are shown in Table 5.

The gas produced was cooled, and the condensed reaction solution that was collected and its gas components were analyzed by gas chromatography (GC-14B, FID and TCD by Shimazu Kagaku, KK.).

The activity of each catalyst was calculated as the grams of acetic acid and ethyl acetate produced per hour per liter of catalyst (space time yield, STY), and the selectivity was calculated as the percentage of product with respect to the starting ethanol.

The reaction results are shown in Table 5.

Table 5

Example No.	Ethanol gas concentration (%)	STY (g/h.lcat)		Conversion rate (%)	Selectivity(%)					
		Ethyl acetate	Acetic acid		Ethyl acetate	Acetic acid	CO <sub>2</sub> *	Acet-aldehyde	Diethyl ether	Ethylene
53	2.5	5	104	98	6	92	2.2	0.1	0.0	0.0
54	5.0	46	175	93	26	72	2.0	0.3	0.3	0.0
55	10	157	120	81	62	31	1.3	0.4	1.1	4.2
56	15	279	75	70	72	14	0.6	0.4	5.5	7.2

\*CO<sub>2</sub>: carbon dioxide

### Industrial Applicability

As explained above, by using an acetic acid production catalyst that contains (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and/or (c) at least one element selected



from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, added to a metallic palladium-loaded catalyst to prepare a catalyst for obtaining acetic acid from ethanol and oxygen, it is possible to achieve production of acetic acid with higher space time yields, lower selectivity for carbon dioxide and acetaldehyde and minimal deterioration, and therefore at higher production efficiency, compared to catalysts of the prior art.

Moreover, by using an acetic acid and ethyl acetate production catalyst that contains (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and/or (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and/or (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, added to a metallic palladium catalyst to prepare a catalyst for obtaining acetic acid and ethyl acetate from ethanol and oxygen, it is possible to achieve production of acetic acid and ethyl acetate with higher space time yields, lower selectivity for carbon dioxide and acetaldehyde and minimal deterioration, and therefore at higher production efficiency, compared to catalysts of the prior art.

CLAIMS

1. A catalyst for production of acetic acid by reaction of ethanol and oxygen, comprising (a) palladium and (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table, held on a carrier.

2. A catalyst for production of acetic acid by reaction of ethanol and oxygen, comprising (a) palladium and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, held on a carrier.

3. A catalyst for production of acetic acid by reaction of ethanol and oxygen, comprising (a) palladium, (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table, held on a carrier.

4. A catalyst according to any one of claims 1 to 3, wherein the (a) palladium is metallic palladium.

5. A catalyst according to any one of claims 1 to 4, wherein the carrier is silica.

6. A catalyst according to claim 1, 3 or 5, wherein the (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is selected from selenium, tellurium, antimony, bismuth, tin and lead.

7. A catalyst according to any one of claims 2 to 6, wherein the (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements,

Group 11 elements and Group 12 elements of the Periodic Table is selected from chromium, gold, manganese and zinc.

5        8.    A process for production of a catalyst for production of acetic acid according to claim 1, which comprises the following steps 1 and 2.

Step 1

10        A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

15        A step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid.

20        9.    A process for production of a catalyst for production of acetic acid according to claim 3, which comprises the following steps 1 and 2.

Step 1

25        A step wherein (a) a palladium compound, (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

Step 2

30        A step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a catalyst for production of acetic acid.

35        10.   A process for production of a catalyst for production of acetic acid according to claim 3, which comprises the following steps 1 to 3.

## Step 1

A step wherein (a) a palladium compound and (c) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a palladium compound-loaded catalyst.

## Step 2

A step wherein the palladium compound-loaded catalyst obtained in step 1 is reduced to obtain a metallic palladium-loaded catalyst.

## Step 3

A step wherein (b) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is loaded on the metallic palladium-loaded catalyst obtained in step 2 to obtain a catalyst for production of acetic acid.

11. A process for production of acetic acid, comprising reacting ethanol and oxygen in the presence of a catalyst for production of acetic acid according to any one of claims 1 to 7.

12. A process according to claim 11, wherein ethanol and oxygen are reacted in the presence of water.

13. A process according to claim 11 or 12, wherein ethanol and oxygen are reacted in a liquid phase.

14. A process according to claim 11 or 12, wherein ethanol and oxygen are reacted in a vapor phase.

15. A process according to claim 14, wherein the concentration of water in the starting gas is 0.1 to 50% by volume.

16. A process according to any one of claims 11 to 15, wherein the starting gas or liquid is blended with acetaldehyde and/or diethyl ether and then the reaction is effected.

17. A catalyst for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen,

comprising (a) palladium and (b) at least one compound selected from the group consisting of inorganic acids and salts thereof.

5 18. A catalyst for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen, comprising (a) palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (c) at least one element selected from the group consisting of Group 14 elements, Group 15  
10 elements and Group 16 elements of the Periodic Table.

19. A catalyst for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen, comprising (a) palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (d) at least one element selected from  
15 the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table.

20 20. A catalyst for production of acetic acid and ethyl acetate by reaction of ethanol and oxygen, comprising (a) palladium, (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, (c) at least one element selected from the  
25 group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements  
30 and Group 12 elements of the Periodic Table.

21. A catalyst according to any one of claims 17 to 20, wherein the (a) palladium is metallic palladium.

22. A catalyst according to any one of claims 17 to 21, wherein the (b) at least one compound selected from  
35 the group consisting of inorganic acids and salts thereof is selected from phosphoric acid and salts thereof, and heteropoly acids and salts thereof.

23. A catalyst according to any one of claims 17 to 22, wherein the (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is selected from heteropoly acids and salts thereof and the heteropoly acids are selected from tungstosilicic acid, tungstophosphoric acid, molybdosilicic acid, molybdophosphoric acid, vanadotungstosilicic acid, vanadotungstophosphoric acid, vanadomolybdosilicic acid and vanadomolybdophosphoric acid.

24. A catalyst according to any one of claims 18 and 20 to 23, wherein the (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table is selected from selenium, tellurium, antimony, bismuth and lead.

25. A catalyst according to any one of claims 19 to 24, wherein the (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table is selected from chromium, gold, manganese and zinc.

26. A catalyst according to any one of claims 17 to 25, wherein the catalyst components are held on a carrier.

27. A catalyst according to claim 26, wherein the carrier is silica.

28. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 17, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and

salts thereof is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

29. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 18, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

30. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 18, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

31. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 19, which comprises the following steps 1 and 2.

## Step 1

A step wherein (a) metallic palladium and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a metallic palladium-loaded catalyst.

## Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

32. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 19, which comprises the following steps 1 and 2.

## Step 1

A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

## Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

33. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 20, which comprises the following steps 1 and 2.

## Step 1

A step wherein (a) metallic palladium, (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16



elements of the Periodic Table and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof is loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

34. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 20, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium is loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof, (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

35. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 20, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium and (d)

at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

36. A process for production of a catalyst for production of acetic acid and ethyl acetate according to claim 20, which comprises the following steps 1 and 2.

Step 1

A step wherein (a) metallic palladium and (c) at least one element selected from the group consisting of Group 14 elements, Group 15 elements and Group 16 elements of the Periodic Table are loaded on a carrier to obtain a metallic palladium-loaded catalyst.

Step 2

A step wherein (b) at least one compound selected from the group consisting of inorganic acids and salts thereof and (d) at least one element selected from the group consisting of Group 6 elements, Group 7 elements, Group 8 elements, Group 9 elements, Group 10 elements, Group 11 elements and Group 12 elements of the Periodic Table are loaded on the metallic palladium-loaded catalyst obtained in step 1 to obtain a catalyst for production of acetic acid and ethyl acetate.

37. A process for production of acetic acid and ethyl acetate, comprising reacting ethanol and oxygen in the presence of a catalyst for production of acetic acid and ethyl acetate according to any one of claims 17 to

27.

38. A process according to claim 37, wherein the ethanol and oxygen are reacted in the presence of water.

5 39. A process according to claim 37 or 38, wherein the ethanol and oxygen are reacted in a liquid phase.

40. A process according to claim 37 or 38, wherein the ethanol and oxygen are reacted in a vapor phase.

10 41. A process according to claim 40, wherein the concentration of water in the starting gas is 0.1 to 50% by volume.

42. A process according to any one of claims 37 to 41, wherein the starting gas or liquid is blended with acetaldehyde and/or diethyl ether and/or ethylene and then the reaction is effected.

15 43. A process according to any one of claims 37 to 41, wherein the starting gas or liquid is blended with acetic acid and then the reaction is effected.

20 44. A process according to claim 43, wherein after obtaining acetic acid and ethyle acetate by reacting ethanol and oxygen, ethyl acetate is separated from the reaction mixture to be collected, while acetic acid is returned to the reaction system to be reacted.

# INTERNATIONAL SEARCH REPORT

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## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C07C51/235 C07C67/40 B01J23/56

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C07C B01J

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

### \* Special categories of cited documents :

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# INTERNATIONAL SEARCH REPORT

International Application No.

PCT/JP 00/02203

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